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(54) **High-density acicular hematite particles, non-magnetic undercoat layer and magnetic recording medium**

(57) High-density acicular hematite particles comprise acicular hematite particles and a coat comprising an oxide of tin or oxides of tin and antimony on at least a part of surfaces of said acicular hematite particles; and have

- an average major axial diameter of not more than 0.3  $\mu\text{m}$ ,
- a pH value of not less than 8,

- a soluble sodium salt content of not more than 300 ppm, calculated as Na, and
- a soluble sulfate content of not more than 150 ppm, calculated as  $\text{SO}_4$ .

Such high-density acicular hematite particles are suitable as non-magnetic particles for a non-magnetic undercoat layer of a magnetic recording medium using magnetic particles containing iron as a main ingredient.

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## Description

The present invention relates to high-density acicular hematite particles, a non-magnetic undercoat layer containing the high-density acicular hematite particles and a magnetic recording medium having the non-magnetic undercoat layer. More particularly, the present invention relates to high-density acicular hematite particles suitable as non-magnetic particles for a non-magnetic undercoat layer of a magnetic recording medium using magnetic particles containing iron as a main ingredient, which have an excellent dispersibility in binder resin, a pH value of not less than 8, a less content of soluble sodium salts and soluble sulfates, and a high surface conductivity; a non-magnetic undercoat layer containing the high-density acicular hematite particles and suitably used for a magnetic recording medium using magnetic particles containing iron as a main ingredient; and a magnetic recording medium having the non-magnetic undercoat layer.

With a development of miniaturized and lightweight video or audio magnetic recording and reproducing apparatuses for long-time recording, magnetic recording media such as a magnetic tape and magnetic disk have been increasingly and strongly required to have a higher performance, namely, a higher recording density, higher output characteristic, in particular, an improved frequency characteristic and a lower noise level.

Various attempts have been made at both enhancing the properties of magnetic particles and reducing the thickness of a magnetic recording layer in order to improve these properties of a magnetic recording medium.

The enhancement of the properties of magnetic particles will first be described.

Magnetic particles are required to have, in order to satisfy the above-described demands on a magnetic recording medium, properties such as a high coercive force and a large saturation magnetization.

As magnetic particles suitable for high-output and high-density recording, acicular magnetic particles containing iron as a main ingredient which are obtained by heat-treating acicular goethite particles or acicular hematite particles in a reducing gas are widely known.

Acicular magnetic particles containing iron as a main ingredient have a high coercive force and a large saturation magnetization, since the acicular magnetic particles containing iron as a main ingredient used for a magnetic recording medium are very fine particles having a particle size of not more than 1  $\mu\text{m}$ , particularly, 0.01 to 0.3  $\mu\text{m}$ . Therefore, such particles easily corrode, and the magnetic properties thereof are deteriorated, especially, the saturation magnetization and the coercive force are reduced.

In order to maintain the characteristics of a magnetic recording medium which uses magnetic particles containing iron as a main ingredient as the magnetic particles, over a long period, it is strongly demanded to suppress the corrosion of the acicular magnetic particles containing iron as a main ingredient as much as possible.

A reduction in the thickness of a magnetic recording layer will now be described.

Video tapes have recently been required more and more to have a higher picture quality, and the frequencies of carrier signals recorded in recent video tapes are higher than those recorded in conventional video tapes. In other words, the signals in the short-wave region have come to be used, and as a result, the magnetization depth from the surface of a magnetic tape has come to be remarkably small.

With respect to short wavelength signals, a reduction in the thickness of a magnetic recording layer is also strongly demanded in order to improve the high output characteristics, especially, an S/N ratio of a magnetic recording medium. This fact is described, for example, on page 312 of Development of Magnetic Materials and Technique for High Dispersion of Magnetic Powder, published by Sogo Gijutsu Center Co., Ltd. (1982), "... the conditions for high-density recording in a coated-layer type tape are that the noise level is low with respect to signals having a short wavelength and that the high output characteristics are maintained. To satisfy these conditions, it is necessary that the tape has large coercive force  $H_c$  and residual magnetization  $B_r$ , ... and the coating film has a smaller thickness ...".

Development of a reduction in the thickness of a magnetic recording layer has caused some problems.

Firstly, it is necessary to make a magnetic recording layer smooth and to eliminate the non-uniformity of thickness. As well known, in order to obtain a smooth magnetic recording layer having a uniform thickness, the surface of the substrate must also be smooth. This fact is described on pages 180 and 181 of Materials for Synthetic Technology- Causes of Friction and Abrasion of Magnetic Tape and Head Running System and Measures for Solving the Problem (hereinafter referred to as "Materials for Synthetic Technology" (1987), published by the Publishing Department of Technology Information Center, "... the surface roughness of a hardened magnetic layer depends on the surface roughness of the substrate (back surface roughness) so largely as to be approximately proportional, ..., since the magnetic layer is formed on the substrate, the more smooth the surface of the substrate is, the more uniform and larger head output is obtained, and the more the S/N ratio is improved."

Secondly, there has been caused a problem in the strength of a non-magnetic substrate such as a base film with a tendency of the reduction in the thickness of the non-magnetic substrate in response to the demand for a thinner magnetic layer. This fact is described, for example, on page 77 of the above-described Development of Magnetic Materials and Technique for High Dispersion of Magnetic Powder, "... Higher recording density is a large problem assigned to the present magnetic tape. This is important in order to shorten the length of the tape and to miniaturize

the size of a cassette and to enable long-time recording. For this purpose, it is necessary to reduce the thickness of a substrate ... With the tendency of reduction in the film thickness, the stiffness of the tape also reduces to such an extent as to make smooth travel in a recorder difficult. Therefore, improvement of the stiffness of a video tape both in the machine direction and in the transverse direction is now strongly demanded. ..."

5 The end portion of a magnetic recording medium such as a magnetic tape, especially, a video tape is judged by detecting a portion of the magnetic recording medium at which the light transmittance is large by a video deck. If the light transmittance of the whole part of a magnetic recording layer is made large by the thinner magnetic recording medium or the ultrafine magnetic particles dispersed in the magnetic recording layer, it is difficult to detect the portion having a large light transmittance by a video deck. For reducing the light transmittance of the whole part of a magnetic recording layer, carbon black or the like is added to the magnetic recording layer. It is, therefore, essential to add carbon black or the like to a magnetic recording layer in the present video tapes.

10 However, addition of a large amount of non-magnetic particles such as carbon black impairs not only the enhancement of the recording density but also the development of a thinner recording layer. Therefore in order to reduce the magnetization depth from the surface of the magnetic tape and to produce a thinner magnetic recording layer, it is strongly demanded to reduce, as much as possible, the quantity of non-magnetic particles such as carbon black which are added to a magnetic recording layer.

15 It is also strongly demanded that the light transmittance of a magnetic recording layer should be small even if the carbon black or the like which is added to the magnetic recording layer is reduced to a small amount. From this point of view, improvements in a substrate are now in strong demand.

20 Further, in order to reduce not only the above-mentioned optical transmittance but also surface resistivity of the magnetic recording medium, carbon black has been conventionally added to a magnetic recording layer thereof.

The use of carbon black in the magnetic recording medium is described in more detail below.

25 In the case where the magnetic recording medium has a high surface resistivity, the electrostatically charged amount on the magnetic recording medium is increased, so that cutting wastes of magnetic recording media or dusts are attached to the surface of magnetic recording medium upon production or use of the magnetic recording medium, thereby increasing occurrence of drop-out.

Consequently, in order to lower the surface resistivity of the magnetic recording medium to about  $10^8 \Omega \text{cm}$ , a conductive compound such as carbon black has been generally added to a magnetic recording layer thereof in an amount of not less than about 5 parts by weight based on 100 parts by weight of magnetic particles used therein.

30 However, such an increase in amount of non-magnetic substance such as carbon black in the magnetic recording layer tends to cause the deterioration in signal recording property and inhibit the reduction in thickness of the magnetic recording layer.

35 Various efforts have been made to improve a base film for a magnetic recording layer with a demand for a thinner magnetic recording layer and a thinner non-magnetic substrate. A magnetic recording medium having at least one undercoat layer (hereinafter referred to "non-magnetic undercoat layer") comprising a binder resin and non-magnetic particles containing iron as a main ingredient such as hematite particles which are dispersed therein, on a non-magnetic substrate such as a base film has been proposed and put to practical use (Japanese Patent Publication (KOKOKU) No. 6-93297 (1994), Japanese Patent Application Laid-Open (KOKAI) Nos. 62-159338 (1987), 63-187418 (1988), 4-167225 (1992), 4-325915 (1992), 5-73882 (1993), 5-182177 (1993), 5-347017 (1993), 6-60362 (1994), 9-35245 (1997), etc.)

40 Further, various attempts for reducing the content of carbon black in the magnetic recording layer and lowering the surface resistivity of the magnetic recording medium as low as possible, have been conducted. For example, it is known that the surfaces of non-magnetic particles dispersed in the above-mentioned non-magnetic undercoat layer are coated with a tin compound or an antimony compound (Japanese Patent Nos. 2566088 and 2566089, Japanese Patent Publication (KOKOKU) No. 5-33446 (1993), Japanese Patent Applications Laid-open (KOKAI) Nos. 6-60360 (1994), 7-176030 (1995), 8-50718 (1996), 8-203063 (1996), 8-255334, 9-27116 (1997) or the like).

45 For example, Japanese Patent Application Laid-Open (KOKAI) No. 5-182177 (1993) discloses a magnetic recording medium comprising: a non-magnetic substrate; a non-magnetic undercoat layer formed on the non-magnetic substrate and produced by dispersing inorganic particles in a binder resin; and a magnetic layer formed on the non-magnetic undercoat layer and produced by dispersing ferromagnetic particles in a binder resin while the non-magnetic undercoat layer is wet; wherein the magnetic layer has a thickness of not more than  $1.0 \mu\text{m}$  in a dried state, the non-magnetic undercoat layer contains non-magnetic inorganic particles with surface layers coated with an inorganic oxide, the inorganic oxide coating the surfaces of the non-magnetic inorganic particles contained in the non-magnetic undercoat layer is at least one selected from the group consisting of  $\text{Al}_2\text{O}_3$ ,  $\text{SiO}_2$  and  $\text{ZrO}_2$ , and the amount of the inorganic oxide coating the non-magnetic inorganic particles is 1 to 21 wt% in the case of  $\text{Al}_2\text{O}_3$ , 0.04 to 20 wt% in the case of  $\text{SiO}_2$ , and 0.05 to 15 wt% in the case of  $\text{ZrO}_2$ , base on the total weight of the magnetic inorganic particles.

55 In Japanese Patent No. 2566088, there is described a magnetic recording medium comprising a non-magnetic substrate, a non-magnetic undercoat layer formed on the non-magnetic substrate, comprising a binder resin and non-

magnetic inorganic particles dispersed in the binder resin and coated with at least one oxide selected from the group consisting of  $\text{Al}_2\text{O}_3$ ,  $\text{SiO}_2$ ,  $\text{ZrO}_2$ ,  $\text{Sb}_2\text{O}_3$  and  $\text{ZnO}$ , and a magnetic uppercoat layer formed on the non-magnetic undercoat layer, comprising a binder resin and ferromagnetic particles dispersed in the binder resin, wherein the magnetic uppercoat layer has a dry thickness of not more than  $1.0\text{ }\mu\text{m}$ ; the non-magnetic undercoat layer has a dry thickness of  $0.5$  to  $10\text{ }\mu\text{m}$ ; and the ferromagnetic particles have a major axial diameter of not more than  $0.3\text{ }\mu\text{m}$ .

At present, there has been more demanded non-magnetic particles for non-magnetic undercoat layer of a magnetic recording medium, which are capable of furnishing a non-magnetic undercoat layer having excellent surface smoothness and mechanical strength by dispersing the non-magnetic particles in a binder resin; which are capable of furnishing a magnetic recording layer having a surface smoothness and a thin and uniform thickness when the magnetic recording layer is formed on the non-magnetic undercoat layer; which are capable of furnishing a magnetic recording medium having a low transmittance and a low surface resistivity; and which are capable of preventing the corrosion of magnetic particles containing iron as a main ingredient, which are dispersed in the magnetic recording layer. However, such non-magnetic particles have not been furnished yet.

That is, it has been reported that the above-mentioned conventional magnetic recording medium using hematite particles as non-magnetic particles for non-magnetic undercoat layer thereof, are improved in surface smoothness and mechanical strength of the non-magnetic undercoat layer; is capable of forming a magnetic recording layer having a surface smoothness, and a thin and uniform thickness upon the formation of the magnetic recording layer; and exhibit a low transmittance. However, these properties reported are still unsatisfactory. Especially, as described in Comparative Examples hereinafter, the surface resistivity of these conventional magnetic recording medium is as high as  $10^9$  to  $10^{11}\text{ }\Omega\text{cm}$ .

On the other hand, in the case of the magnetic recording medium having the non-magnetic undercoat layer containing non-magnetic particles coated with a tin compound or an antimony compound and dispersed in a binder resin, the non-magnetic undercoat layer is deteriorated in surface smoothness and mechanical strength, though the surface resistivity thereof is low. Accordingly, the magnetic recording layer formed on such a non-magnetic undercoat layer necessarily has a rough surface and an uneven thickness, and exhibit an unsatisfactory transmittance.

Further, there has also been pointed out such a problem that the magnetic particles containing iron as a main ingredient, which are dispersed in the magnetic recording layer, undergo severe corrosion after the production of the magnetic recording medium, thereby causing the considerable deterioration in magnetic properties thereof.

As a result of the present inventors' earnest studies for solving the above-mentioned problems, it has been found that by coating at least a part of surfaces of specific acicular hematite particles with an oxide of tin or an oxide of tin and antimony, and controlling the pH value to not less than 8 and contents of soluble sodium salts and soluble sulfates to a certain range, the obtained high-density acicular hematite particles exhibit a low surface resistivity and an excellent dispersibility in a vehicle. The present invention has been attained on the basis of this finding.

It is an object of the present invention to provide non-magnetic particles for non-magnetic undercoat layer of a magnetic recording medium, which are capable of furnishing a non-magnetic undercoat layer having excellent surface smoothness and mechanical strength by dispersing the non-magnetic particles in a binder resin; which are capable of furnishing a magnetic recording layer having a surface smoothness and a thin and uniform thickness upon the formation of the magnetic recording layer; which are capable of furnishing a magnetic recording medium having a low transmittance and a low surface resistivity; and which are capable of preventing the corrosion of metal magnetic particles containing iron as a main ingredient, which are dispersed in the magnetic recording layer.

It is another object of the present invention to provide a non-magnetic undercoat layer which has excellent surface smoothness and mechanical strength, which is capable of forming thereon a magnetic recording layer, which is capable of imparting an excellent surface smoothness, a low transmittance and a low surface resistivity to the magnetic recording layer when formed on the non-magnetic undercoat layer, and which is capable of preventing metal magnetic particles containing iron as a main ingredient, which are dispersed in the magnetic recording layer, from being corroded, thereby inhibiting the deterioration in magnetic properties thereof.

It is other object of the present invention to provide a magnetic recording medium which has an excellent surface smoothness, a low transmittance and a low surface resistivity, and in which the corrosion of metal magnetic particles containing iron as a main ingredient, which are dispersed in the magnetic recording layer, is prevented, thereby inhibiting the deterioration in magnetic properties thereof.

To accomplish the aim, in a first aspect of the present invention, there is provided high-density acicular hematite particles comprising acicular hematite particles and a coat comprising an oxide of tin or oxides of tin and antimony, formed on at least a part of surfaces of the acicular hematite particles; and having an average major axial diameter of not more than  $0.3\text{ }\mu\text{m}$ , a pH value of not less than 8, a soluble sodium salt content of not more than 300 ppm (calculated as Na) and a soluble sulfate content of not more than 150 ppm (calculated as  $\text{SO}_4$ ).

In a second aspect of the present invention, there is provided high-density acicular hematite particles comprising acicular hematite particles, a first coat comprising an oxide of tin or oxides of tin and antimony, formed on at least a part of surfaces of the acicular hematite particles, and a second coat comprising at least one compound selected from

the group consisting of a hydroxide of aluminum, an oxide of aluminum, a hydroxide of silicon and an oxide of silicon, formed on at least a part of surfaces of said high-density acicular hematite particles; and

having an average major axial diameter of not more than  $0.3\text{ }\mu\text{m}$ , a pH value of not less than 8, a soluble sodium salt content of not more than 300 ppm (calculated as Na) and a soluble sulfate content of not more than 150 ppm (calculated as  $\text{SO}_4$ ).

In a third aspect of the present invention, there is provided a non-magnetic undercoat layer comprising the high-density acicular hematite particles set forth in the first or second aspect and a binder resin, formed on a non-magnetic substrate.

In a fourth aspect of the present invention, there is provided a magnetic recording medium comprising:

a non-magnetic substrate;

a non-magnetic undercoat layer comprising the high-density acicular hematite particles set forth in the first or second aspect and a binder resin, formed on said non-magnetic substrate; and

a magnetic recording layer comprising magnetic particles containing iron as a main ingredient and a binder resin, formed on said non-magnetic undercoat layer.

In a fifth aspect of the present invention, there is provided a process for producing high-density acicular hematite particles set forth in claim 1, comprising:

heat-dehydrating acicular goethite particles coated with a hydroxide of tin to obtain low-density acicular hematite particles;

heat-treating said low-density acicular hematite particles at a temperature of not less than  $550^\circ\text{C}$  to obtain high-density acicular hematite particles coated with an oxide of tin;

wet-pulverizing a slurry containing said high-density acicular hematite particles;

adjusting the pH value of said slurry to not less than 13;

heat-treating said slurry at a temperature of not less than  $80^\circ\text{C}$ ; and

filtering said slurry to separate high-density acicular hematite particles therefrom, followed by washing with water and drying.

In a sixth aspect of the present invention, there is provided a process for producing high-density acicular hematite particles set forth in claim 1, comprising:

wet-pulverizing a slurry containing high-density acicular hematite particles obtained by heat-treating at a temperature of not less than  $550^\circ\text{C}$  low-density acicular hematite particles produced by heat-dehydrating acicular goethite particles coated with a sintering preventive agent;

adjusting the pH value of said slurry to not less than 13;

heat-treating said slurry at a temperature of not less than  $80^\circ\text{C}$ ; and

filtering said slurry to separate high-density acicular hematite particles therefrom, followed by washing with water and drying;

treating the obtained high-density acicular hematite particles with an aqueous solution containing a tin compound to obtain high-density acicular hematite particles coated with a hydroxide of tin; and

heat-treating said high-density acicular hematite particles coated with a hydroxide of tin at a temperature of not less than  $300^\circ\text{C}$ .

In a seventh aspect of the present invention, there is provided a process for producing high-density acicular hematite particles set forth in claim 1, comprising:

heat-dehydrating acicular goethite particles coated with hydroxides of tin and antimony to obtain low-density acicular hematite particles;

heat-treating said low-density acicular hematite particles at a temperature of not less than  $550^\circ\text{C}$  to obtain high-density acicular hematite particles coated with oxides of tin and antimony;

wet-pulverizing a slurry containing said high-density acicular hematite particles;

adjusting the pH value of said slurry to not less than 13;

heat-treating said slurry at a temperature of not less than  $80^\circ\text{C}$ ; and

filtering said slurry to separate high-density acicular hematite particles therefrom, followed by washing with water and drying.

In an eighth aspect of the present invention, there is provided a process for producing high-density acicular hematite

particles set forth in claim 1, comprising:

wet-pulverizing a slurry containing high-density acicular hematite particles obtained by heat-treating at a temperature of not less than 550°C low-density acicular hematite particles produced by heat-dehydrating acicular goethite particles coated with a sintering preventive agent,;  
 adjusting the pH value of said slurry to not less than 13;  
 heat-treating said slurry at a temperature of not less than 80°C; and  
 filtering said slurry to separate high-density acicular hematite particles therefrom, followed by washing with water and drying;  
 treating the obtained high-density acicular hematite particles with an aqueous solution containing a tin compound and an antimony compound to obtain high-density acicular hematite particles coated with hydroxides of tin and antimony; and  
 heat-treating said high-density acicular hematite particles coated with hydroxides of tin and antimony at a temperature of not less than 300°C.

The present invention is described in detail below.

First, the high-density acicular hematite particles in which at least a part of the surface thereof is coated with an oxide of tin or an oxide of tin and antimony, are described.

The amount of the oxide of tin coated on surface of the particles is usually 0.5 to 500 % by weight (calculated as Sn) based on the weight of the acicular hematite particles. When the amount of the oxide of tin is less than 0.5 % by weight, the surface of the particles cannot be satisfactorily coated with the oxide of tin as a conductive substance, so that it becomes impossible to attain a sufficient effect of reducing a surface resistivity of the magnetic recording medium. On the other hand, when the amount of the oxide of tin is more than 500 % by weight, although a sufficient effect of reducing a surface resistivity of the magnetic recording medium can be obtained, the effect is already saturated and, therefore, the use of such an excessive amount of the oxide of tin is meaningless. In view of the surface resistivity of the obtained magnetic recording medium and economy of the production thereof, the amount of the oxide of tin is preferably 1.0 to 250 % by weight, more preferably 2.0 to 200 % by weight (calculated as Sn) based on the weight of the acicular hematite particles.

The amount of the oxide of antimony coated on surfaces of the particles is usually not more than 50 % by weight, preferably 0.05 to 50 % by weight (calculated as Sb) based on the weight of the acicular hematite particles. When the amount of the oxide of antimony is more than 50 % by weight, although a sufficient effect of reducing a surface resistivity of the magnetic recording medium can be obtained, the effect is already saturated and, therefore, the use of such an excessive amount of the oxide of antimony is meaningless. In view of the surface resistivity of the obtained magnetic recording medium and economy of the production thereof, the amount of the oxide of antimony is more preferably 0.1 to 25 % by weight (calculated as Sb) based on the weight of the acicular hematite particles.

In the case where the surface of the particles are coated with the oxide of tin and antimony, the weight ratio of tin to antimony is usually 20:1 to 1:1, preferably 15:1 to 2:1. When the amount of tin is less than that of antimony, it may become difficult to effectively reduce a surface resistivity of the magnetic recording medium. When the weight ratio of tin to antimony exceeds 20, it may become difficult to more effectively reduce a surface resistivity of the magnetic recording medium, because the amount of tin is too small.

The high-density acicular hematite particles coated with the oxide of tin or the oxides of tin and antimony according to the present invention have an average major axial diameter of not more than 0.3  $\mu\text{m}$ , a pH value of not less than 8, a soluble sodium salt content of not more than 300 ppm (calculated as Na) and a soluble sulfate content of not more than 150 ppm (calculated as  $\text{SO}_4$ ).

The high-density acicular hematite particles in the present invention have an aspect ratio (average major axial diameter/average minor axial diameter) (hereinafter referred to merely as "aspect ratio") of not less than 2 : 1, preferably not less than 3 : 1. The upper limit of the aspect ratio is usually 20 : 1, preferably 10 : 1 with the consideration of the dispersibility in the vehicle. The shape of the acicular particles here may have not only acicular but also spindle-shaped, rice ball-shaped or the like.

When the aspect ratio is less than 2 : 1, it is difficult to obtain a desired film strength of the magnetic recording medium.

The average major axial diameter of the high-density acicular hematite particles of the present invention is not more than 0.3  $\mu\text{m}$ , preferably 0.005 to 0.3  $\mu\text{m}$ . When the average major axial diameter exceeds 0.3  $\mu\text{m}$ , the particle size is so large as to impair the surface smoothness. With the consideration of the dispersibility in the vehicle and the surface smoothness of the coated film, the more preferable average major axial diameter is 0.02 to 0.2  $\mu\text{m}$ .

The average minor axial diameter of the high-density acicular hematite particles of the present invention is usually 0.0025 to 0.15  $\mu\text{m}$ . When the average minor axial diameter is less than 0.0025  $\mu\text{m}$ , dispersion in the vehicle may be unfavorably difficult. On the other hand, when the average minor axial diameter exceeds 0.15  $\mu\text{m}$ , the particle size

may be apt to become so large as to impair the surface smoothness. With the consideration of the dispersibility in the vehicle and the surface smoothness of the coated film, the more preferable average minor axial diameter is 0.01 to 0.10  $\mu\text{m}$ .

The BET specific surface area of the high-density acicular hematite particle of the present invention is usually not less than 35  $\text{m}^2/\text{g}$ . When it is less than 35  $\text{m}^2/\text{g}$ , the acicular hematite particles may be coarse or sintering may be sometimes caused between particles, which are apt to exert a deleterious influence on the surface smoothness of the coated film. The BET surface area thereof is more preferably not less than 40  $\text{m}^2/\text{g}$ , even more preferably not less than 45  $\text{m}^2/\text{g}$ , and the upper limit thereof is usually 150  $\text{m}^2/\text{g}$ . The upper limit is preferably 100  $\text{m}^2/\text{g}$ , more preferably 80  $\text{m}^2/\text{g}$  with the consideration of the dispersibility in the vehicle.

The degree of densification ( $S_{\text{BET}}/S_{\text{TEM}}$ ) of hematite particles is represented by the ratio of the specific surface area ( $S_{\text{BET}}$ ) measured by a BET method and the surface area ( $S_{\text{TEM}}$ ) calculated from the major axial diameter and the minor axial diameter which were measured from the particles in an electron micrograph.

The  $S_{\text{BET}}/S_{\text{TEM}}$  value of hematite particles according to the present invention is usually 0.5 to 2.5. When the  $S_{\text{BET}}/S_{\text{TEM}}$  value is less than 0.5, although the hematite particles have been densified, the particles may adhere to each other due to sintering therebetween, and the particle size may increase, so that a sufficient surface smoothness of the coated film may be not obtained. On the other hand, when the  $S_{\text{BET}}/S_{\text{TEM}}$  value exceeds 2.5, there may be many pores in the surfaces of particles and the dispersibility in the vehicle may become insufficient. In consideration of the surface smoothness of the coated film and the dispersibility in the vehicle, the  $S_{\text{BET}}/S_{\text{TEM}}$  value is preferably 0.7 to 2.0, more preferably 0.8 to 1.6.

The major axial diameter distribution of the high-density acicular hematite particles of the present invention is preferably not more than 1.50 in geometrical standard deviation. When it exceeds 1.50, the coarse particles existent sometimes exert a deleterious influence on the surface smoothness of the coated film. The major axial diameter distribution is more preferably not more than 1.40, even more preferably not more than 1.35 in geometrical standard deviation with the consideration of the surface smoothness of the coated film. From the point of view of industrial productivity, the major axial diameter distribution of the high-density acicular hematite particles obtained is usually 1.01 in geometrical standard deviation.

The pH value of the high-density acicular hematite particles of the present invention is not less than 8. When it is less than 8, the magnetic particles containing iron as a main ingredient contained in the magnetic recording layer formed on the non-magnetic undercoat layer are gradually corroded, thereby causing a deterioration in the magnetic properties. With the consideration of a corrosion preventive effect on the magnetic particles containing iron as a main ingredient, the pH value of the particles is preferably not less than 8.5, more preferably not less than 9.0. The upper limit is usually 12, preferably 11, more preferably 10.5.

The content of soluble sodium salts in the high-density acicular hematite particles of the present invention is not more than 300 ppm soluble sodium (calculated as Na). When it exceeds 300 ppm, the magnetic particles containing iron as a main ingredient contained in the magnetic recording layer formed on the non-magnetic undercoat layer are gradually corroded, thereby causing a deterioration in the magnetic properties. In addition, the dispersion property of the high-density acicular hematite particles in the vehicle is easily impaired, and the preservation of the magnetic recording medium is deteriorated and efflorescence is sometimes caused in a highly humid environment. With the consideration of a corrosion preventive effect on the magnetic particles containing iron as a main ingredient, the content of soluble sodium salt is preferably not more than 250 ppm, more preferably not more than 200 ppm, even more preferably not more than 150 ppm. From the point of view of industry such as productivity, the lower limit thereof is preferably about 0.01 ppm.

The content of soluble sulfate in the high-density acicular hematite particles of the present invention is not more than 150 ppm soluble sulfate (calculated as  $\text{SO}_4$ ). When it exceeds 150 ppm, the magnetic particles containing iron as a main ingredient contained in the magnetic recording layer formed on the non-magnetic undercoat layer are gradually corroded, thereby causing a deterioration in the magnetic properties. In addition, the dispersion property of the high-density acicular hematite particles in the vehicle is easily impaired, and the preservation of the magnetic recording medium is deteriorated and efflorescence is sometimes caused in a highly humid environment. With the consideration of a corrosion preventive effect on the magnetic particles containing iron as a main ingredient, the content of soluble sulfate is preferably not more than 70 ppm, more preferably not more than 50 ppm. From the point of view of industry such as productivity, the lower limit thereof is preferably about 0.01 ppm.

The high-density acicular hematite particles according to the present invention in which at least a part of the surface thereof is coated with the oxide of tin or the oxide of tin and antimony, have a volume resistivity of  $10^3$  to  $5 \times 10^7 \Omega\text{cm}$ . When the volume resistivity of acicular hematite particles is more than  $10^8 \Omega\text{cm}$ , it may become difficult to obtain a magnetic recording medium having a sufficiently low surface resistivity.

At least a part of the surfaces of the high-density acicular hematite particles coated of the present invention may be coated with at least one selected from the group consisting of a hydroxide of aluminum, an oxide of aluminum, a hydroxide of silicon and an oxide of silicon. When the acicular hematite particles coated with the above-described

coating material are dispersed in a vehicle, they have an affinity with the binder resin and it is easy to obtain a desired dispersibility.

The amount of aluminum hydroxide, aluminum oxide, silicon hydroxide or silicon oxide used as the coating material is usually not less than 50 wt%, preferably 0.01 to 50 wt% (calculated as Al or SiO<sub>2</sub>). When it is less than 0.01 wt%, the dispersibility improving effect may be insufficient. When the amount exceeds 50 wt%, the coating effect becomes saturated, so that it is meaningless to add a coating material more than necessary. From the point of view of dispersibility in the vehicle, the preferable amount of coating material is preferably 0.05 to 20 wt% (calculated as Al or SiO<sub>2</sub>).

Various properties of the high-density acicular hematite particles coated with a coating material of the present invention, such as aspect ratio, average major axial diameter, average minor axial diameter, pH value, the content of soluble sodium salt, content of soluble sulfate, BET specific surface area, major axial diameter distribution, degree of densification, and volume resistivity are approximately equivalent in values to those of the high-density acicular hematite particles of the present invention the surfaces of which are not coated with a coating material.

A non-magnetic undercoat layer and a magnetic recording medium according to the present invention will now be explained.

The magnetic medium of according to the present invention comprises a non-magnetic substrate, a non-magnetic undercoat layer and a magnetic recording layer.

The non-magnetic undercoat layer of the present invention is produced by forming a coating film on the non-magnetic substrate and drying the coating film. The non-magnetic coating film is formed by applying to the surface of the non-magnetic substrate a non-magnetic coating composition which contains the high-density acicular hematite particles, a binder resin and a solvent.

As the non-magnetic substrate, the following materials which are at present generally used for the production of a magnetic recording medium are usable as a raw material: a synthetic resin such as polyethylene terephthalate, polyethylene, polypropylene, polycarbonate, polyethylene naphthalate, polyamide, polyamideimide and polyimide; foil and plate of a metal such as aluminum and stainless steel; and various kinds of paper. The thickness of the non-magnetic substrate varies depending upon the material, but it is usually about 1.0 to 300  $\mu\text{m}$ , preferably 2.0 to 200  $\mu\text{m}$ . In the case of a magnetic disc, polyethylene terephthalate is ordinarily used as the non-magnetic substrate. The thickness thereof is usually 50 to 300  $\mu\text{m}$ , preferably 60 to 200  $\mu\text{m}$ . In the case of a magnetic tape, when polyethylene terephthalate is used as the non-magnetic substrate, the thickness thereof is usually 3 to 100  $\mu\text{m}$ , preferably 4 to 20  $\mu\text{m}$ . When polyethylene naphthalate is used, the thickness thereof is usually 3 to 50  $\mu\text{m}$ , preferably 4 to 20  $\mu\text{m}$ . When polyamide is used, the thickness thereof is usually 2 to 10  $\mu\text{m}$ , preferably 3 to 7  $\mu\text{m}$ .

The thickness of the non-magnetic undercoat layer obtained by coating the non-magnetic substrate with a coating composition and drying the coating film, is usually 0.2 to 10.0  $\mu\text{m}$ , preferably 0.5 to 5.0  $\mu\text{m}$ . When the thickness is less than 0.2  $\mu\text{m}$ , not only it is impossible to ameliorate the surface roughness of the non-magnetic substrate but also the strength is insufficient.

As the binder resin in the present invention, the following resins which are at present generally used for the production of a magnetic recording medium are usable: vinyl chloride-vinyl acetate copolymer, urethane resin, vinyl chloride-vinyl acetate-maleic acid copolymer, urethane elastomer, butadiene-acrylonitrile copolymer, polyvinyl butyral, cellulose derivative such as nitrocellulose, polyester resin, synthetic rubber resin such as polybutadiene, epoxy resin, polyamide resin, polyisocyanate, electron radiation curing acryl urethane resin and mixtures thereof. Each of these resin binders may contain a functional group such as -OH, -COOH, -SO<sub>3</sub>M, -OPO<sub>2</sub>M<sub>2</sub> and -NH<sub>2</sub>, wherein M represents H, Na or K. With the consideration of the dispersibility of the particles, a binder resin containing a functional group -COOH or -SO<sub>3</sub>M is preferable.

The mixing ratio of the high-density acicular hematite particles with the binder resin is usually 5 to 2000 parts by weight, preferably 100 to 1000 parts by weight based on 100 parts by weight of the binder resin.

It is possible to add a lubricant, a polishing agent, an antistatic agent, etc. which are generally used for the production of a magnetic recording medium to the non-magnetic undercoat layer.

The gloss of the coated film of the non-magnetic undercoat layer containing high-density acicular hematite particles according to the present invention is usually 180 to 280%, preferably 185 to 280%, more preferably 187 to 280% and the surface roughness Ra thereof is usually 2.0 to 13.0 nm, preferably 2.0 to 11.0 nm, more preferably 2.0 to 10.0 nm. The Young's modulus (relative value to a commercially available video tape: AV T-120 produced by Victor Company of Japan, Limited) thereof is usually 115 to 150, preferably 120 to 150, more preferably 125 to 150.

The magnetic recording medium according to the present invention is produced by forming the non-magnetic undercoat layer formed on the non-magnetic substrate, forming a coating film on the non-magnetic undercoat layer by applying a coating composition containing magnetic particles containing iron as a main ingredient, a binder resin and a solvent, and drying the coating film to obtain a magnetic recording layer.

The magnetic particles containing iron as a main ingredient used in the present invention comprises iron or iron and at least one selected from the group consisting of Co, Al, Ni, P, Si, Zn, Ti, Cu, B, Nd, La and Y. Further, the following magnetic particles containing iron as a main ingredient may be exemplified.

1) Magnetic particles containing iron as a main ingredient comprises iron and usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of aluminum (calculated as Al) based on the weight of the magnetic particles containing iron as a main ingredient.

2) Magnetic particles containing iron as a main ingredient comprises iron; usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of aluminum (calculated as Al) based on the weight of the magnetic particles containing iron as a main ingredient; and usually 0.05 to 40 wt%, preferably 1.0 to 35 wt%, more preferably 3 to 30 wt% of cobalt (calculated as Co) based on the weight of the magnetic particles containing iron as a main ingredient.

3) Magnetic particles containing iron as a main ingredient comprises iron; usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of aluminum (calculated as Al) based on the weight of the magnetic particles containing iron as a main ingredient; and usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of at least one selected from the group consisting of Nd, La and Y (calculated as the corresponding element) based on the weight of the magnetic particles containing iron as a main ingredient.

4) Magnetic particles containing iron as a main ingredient comprises iron; usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of aluminum (calculated as Al) based on the weight of the magnetic particles containing iron as a main ingredient; usually 0.05 to 40 wt%, preferably 1.0 to 35 wt%, more preferably 3 to 30 wt% of cobalt (calculated as Co) based on the weight of the magnetic particles containing iron as a main ingredient; and usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of at least one selected from the group consisting of Nd, La and Y (calculated as the corresponding element) based on the weight of the magnetic particles containing iron as a main ingredient.

5) Magnetic particles containing iron as a main ingredient comprises iron; usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of aluminum (calculated as Al) based on the weight of the magnetic particles containing iron as a main ingredient; and usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of at least one selected from the group consisting of Ni, P, Si, Zn, Ti, Cu and B (calculated as the corresponding element) based on the weight of the magnetic particles containing iron as a main ingredient.

6) Magnetic particles containing iron as a main ingredient comprises iron; usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of aluminum (calculated as Al) based on the weight of the magnetic particles containing iron as a main ingredient; usually 0.05 to 40 wt%, preferably 1.0 to 35 wt%, more preferably 3 to 30 wt% of cobalt (calculated as Co) based on the weight of the magnetic particles containing iron as a main ingredient; and usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of at least one selected from the group consisting of Ni, P, Si, Zn, Ti, Cu and B (calculated as the corresponding element) based on the weight of the magnetic particles containing iron as a main ingredient.

7) Magnetic particles containing iron as a main ingredient comprises iron; usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of aluminum (calculated as Al) based on the weight of the magnetic particles containing iron as a main ingredient; usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of at least one selected from the group consisting of Nd, La and Y (calculated as the corresponding element) based on the weight of the magnetic particles containing iron as a main ingredient; and usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of at least one selected from the group consisting of Ni, P, Si, Zn, Ti, Cu and B (calculated as the corresponding element) based on the weight of the magnetic particles containing iron as a main ingredient.

8) Magnetic particles containing iron as a main ingredient comprises iron; usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of aluminum (calculated as Al) based on the weight of the magnetic particles containing iron as a main ingredient; usually 0.05 to 40 wt%, preferably 1.0 to 35 wt%, more preferably 3 to 30 wt% of cobalt (calculated as Co) based on the weight of the magnetic particles containing iron as a main ingredient; usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of at least one selected from the group consisting of Nd, La and Y (calculated as the corresponding element) based on the weight of the magnetic particles containing iron as a main ingredient; and usually 0.05 to 10 wt%, preferably 0.1 to 7 wt% of at least one selected from the group consisting of Ni, P, Si, Zn, Ti, Cu and B (calculated as the corresponding element) based on the weight of the magnetic particles containing iron as a main ingredient.

The iron content in the particles is the balance, and is preferably 50 to 99 wt%, more preferably 60 to 95 wt% (calculated as Fe) based on the weight of the magnetic particles containing iron as a main ingredient.

The magnetic particles containing iron as a main ingredient comprising (i) iron and Al; (ii) iron, Al and Co, (iii) iron, Al and at least one rare-earth metal such as Nd, La and Y, or (iv) iron, Al, Co and at least one rare-earth metal such as Nd, La and Y, are preferable from the point of the durability of the magnetic recording medium. Further, the magnetic particles containing iron as a main ingredient comprising iron, Al and at least one rare-earth metal such as Nd, La and Y, are more preferable.

The acicular magnetic particles containing iron as a main ingredient used in the present invention have an average major axial diameter of usually 0.01 to 0.50  $\mu\text{m}$ , preferably 0.03 to 0.30  $\mu\text{m}$ , more preferably 0.03 to 0.25  $\mu\text{m}$ , an average minor axial diameter of usually 0.0007 to 0.17  $\mu\text{m}$ , preferably 0.003 to 0.10  $\mu\text{m}$ , and an aspect ratio of usually not less than 3 : 1, preferably and not less than 5 : 1. The upper limit of the aspect ratio is usually 15 : 1, preferably

10 : 1 with the consideration of the dispersibility in the vehicle. The shape of the acicular magnetic particles containing iron as a main ingredient may have not only acicular but also a spindle-shaped, rice ball-shaped or the like.

As to the magnetic properties of the acicular magnetic particles containing iron as a main ingredient used in the present invention, the coercive force is preferably 1200 to 3200 Oe, more preferably 1500 to 3200 Oe, and the saturation magnetization is preferably 100 to 170 emu/g, more preferably 130 to 170 emu/g with the consideration of the properties such as high-density recording.

As the binder resin for the magnetic recording layer, the same binder resin as that used for the production of the non-magnetic undercoat layer is usable.

The thickness of the magnetic recording layer obtained by applying the magnetic coating composition to the non-magnetic undercoat layer and dried, is ordinarily in the range of 0.01 to 5.0  $\mu\text{m}$ . When the thickness is less than 0.01  $\mu\text{m}$ , uniform coating may be difficult, so that unfavorable phenomenon such as unevenness on the coating surface is observed. On the other hand, when the thickness exceeds 5.0  $\mu\text{m}$ , it may be difficult to obtain desired signal recording property due to an influence of diamagnetism. The preferable thickness is in the range of 0.05 to 1.0  $\mu\text{m}$ .

The mixing ratio of the acicular magnetic particles containing iron as a main ingredient with the binder resin in the magnetic recording layer is usually 200 to 2000 parts by weight, preferably 300 to 1500 parts by weight based on 100 parts by weight of the binder resin.

It is possible to add a lubricant, a polishing agent, an antistatic agent, etc. which are generally used for the production of a magnetic recording medium to the magnetic recording layer.

The magnetic recording medium according to the present invention has a coercive force of usually 900 to 3500 Oe, preferably 1000 to 3500 Oe, more preferably 1500 to 3500 Oe; a squareness (residual magnetic flux density  $B_r$ /saturation magnetic flux density  $B_m$ ) of usually 0.85 to 0.95, preferably 0.87 to 0.95; a gloss (of the coating film) of usually 195 to 300%, preferably 200 to 300%; a surface roughness  $R_a$  (of the coating film) of usually not more than 11.0 nm, preferably 1.0 to 10.0 nm, more preferably 1.0 to 9.0 nm; a Young's modulus (relative value to a commercially available video tape: AV T-120 produced by Victor Company of Japan, Limited) of usually not less than 125, preferably not less than 130; a linear adsorption coefficient (of the coating film) of usually 1.10 to 2.00  $\mu\text{m}^{-1}$ , preferably 1.20 to 2.00  $\mu\text{m}^{-1}$ ; and a surface resistivity (of the coating film) of usually  $10^4$  to  $5 \times 10^8 \Omega/\text{sq}$ , preferably  $10^4$  to  $4.5 \times 10^8 \Omega/\text{sq}$ , more preferably  $10^4$  to  $4 \times 10^8 \Omega/\text{sq}$ .

The corrosiveness represented by a percentage (%) of change in the coercive force is usually not more than 10.0 %, preferably not more than 9.5%, and the corrosiveness represented by a percentage (%) of change in the saturation magnetic flux density  $B_m$  is usually not more than 10.0 %, preferably not more than 9.5%.

Next, the process for producing the high-density acicular hematite particles coated with an oxide of tin or both an oxide of tin and an oxide of antimony according to the present invention, is described below.

As a starting material for the acicular hematite particles, there may be used acicular goethite particles.

In order to produce the high-density acicular hematite particles of the present invention, acicular goethite particles are produced. Acicular goethite particles are produced by an ordinary method:

(A) a method of oxidizing a suspension having a pH value of not less than 11 and containing colloidal ferrous hydroxide particles which is obtained by adding not less than an equivalent of an alkali hydroxide solution to an aqueous ferrous salt solution, by passing an oxygen-containing gas thereinto at a temperature of not higher than 80°C;

(B) a method of producing acicular goethite particles by oxidizing a suspension containing  $\text{FeCO}_3$  which is obtained by reacting an aqueous ferrous salt solution with an aqueous alkali carbonate solution, by passing an oxygen-containing gas thereinto after aging, if necessary, the suspension;

(C) a method of growing acicular seed goethite particles by oxidizing a ferrous hydroxide solution containing colloidal ferrous hydroxide particles which is obtained by adding less than an equivalent of an alkali hydroxide solution or an alkali carbonate solution to an aqueous ferrous salt solution, by passing an oxygen-containing gas thereinto, thereby producing acicular seed goethite particles, adding not less than an equivalent of an alkali hydroxide solution to the  $\text{Fe}^{2+}$  in the aqueous ferrous salt solution, to the aqueous ferrous salt solution containing the acicular goethite seed particles, and passing an oxygen-containing gas into the aqueous ferrous salt solution; and

(D) a method of growing acicular seed goethite particles by oxidizing a ferrous hydroxide solution containing colloidal ferrous hydroxide particles which is obtained by adding less than an equivalent of an alkali hydroxide solution or an alkali carbonate solution to an aqueous ferrous salt solution, by passing an oxygen-containing gas thereinto, thereby producing acicular seed goethite particles, and growing the obtained acicular seed goethite particles in an acidic or neutral region.

Elements other than Fe such as Ni, Zn, P, Al and Si, which are generally added in order to enhance various properties of the particles such as the major axial diameter, the minor axial diameter and the aspect ratio, may be added during the reaction system for producing the goethite particles.

The acicular goethite particles obtained have an average major axial diameter of usually 0.005 to 0.4  $\mu\text{m}$ , an average minor axial diameter of usually 0.0025 to 0.20  $\mu\text{m}$  and a BET specific of about usually 50 to 250  $\text{m}^2/\text{g}$ , and contain ordinarily soluble sodium salts of 300 to 1500 ppm soluble sodium (calculated as Na) and ordinarily soluble sulfates of 100 to 3000 ppm soluble sulfate (calculated as  $\text{SO}_4$ ).

The surfaces of the above-mentioned acicular goethite particles are then coated with a hydroxide of tin or hydroxides of tin and antimony.

In the coating-treatment, a tin compound or a tin compound and an antimony compound is added to a water suspension obtained by dispersing the acicular goethite particles in an aqueous solution. The suspension is stirred and if required, the pH value of the suspension is adjusted properly to coat the acicular goethite particles with the hydroxide of tin or the hydroxides of tin and antimony. Then, the suspension is then filtered to separate the coated acicular goethite particles therefrom. The coated acicular goethite particles is further washed with water, dried and pulverized.

As the tin compound added, there may be exemplified alkali stannates such as sodium stannate, tin salts such as stannous chloride, stannic chloride, stannous sulfate, stannic sulfate, stannous nitrate, stannic nitrate, stannous acetate or stannic acetate, or the like. The amount of the tin compound added is usually 0.5 to 500 % by weight, preferably 1 to 250 % by weight (calculated as Sn) based on the weight of the acicular goethite particles. When the amount of the tin compound added is less than 0.5 % by weight, the acicular goethite particles cannot be sufficiently coated with the hydroxide of tin. On the other hand, when the amount of the tin compound added is more than 500 % by weight, the effect by the addition is saturated and, therefore, the addition of such an excessive amount of the tin compound is meaningless.

As the antimony compound added, there may be exemplified antimony salts such as antimonous chloride, antimonous chloride or antimony sulfate. The amount of the antimony compound added is usually not more than 50 % by weight, preferably 0.05 to 50 % by weight (calculated as Sb) based on the weight of the acicular goethite particles. When the amount of the antimony compound added is more than 50 % by weight, the effect by the addition is saturated and, therefore, the addition of such an excessive amount of the antimony compound is meaningless.

The thus obtained acicular goethite particles coated with the hydroxide of tin or the hydroxides of tin and antimony are heated at a temperature as high as not less than 550°C to produce high-density acicular hematite particles. Alternatively, the coated acicular goethite particles may be heat-dehydrated at a temperature of 250 to 500°C form low-density acicular hematite particles, and then, are heat-treated at a temperature as high as not less than 550°C to produce high-density acicular hematite particles. In order to obtain the high-density acicular hematite particles maintaining the shape or configuration of original acicular goethite particles, the latter method is preferred.

It is preferred to coat the particles with a sintering preventive before the heat-treatment at a high temperature in order to obtain high-density acicular hematite particles which retain the shapes of the acicular goethite particles. The acicular goethite particles coated with a sintering preventive contain soluble sodium salts of usually 500 to 2000 ppm soluble sodium (calculated as Na) and soluble sulfates of usually 300 to 3000 ppm soluble sulfate (calculated as  $\text{SO}_4$ ), and have the BET specific surface area of usually about 50 to 250  $\text{m}^2/\text{g}$ . The coating-treatment using a sintering preventive is composed of the steps of: adding a sintering preventive to an aqueous suspension containing the acicular goethite particles, mixing and stirring the suspension, filtering out the particles, washing the particles with water, and drying the particles.

Incidentally, in the case of the acicular goethite particles coated with the hydroxide of tin or the hydroxides of tin and antimony, the hydroxide of tin or the hydroxides of tin and antimony works on as sintering-preventive agent, and therefore, such coated acicular goethite particles may further be coated with the sintering-preventive agent.

The amount of sintering preventive existent on the surfaces of the acicular hematite particles of the present invention varies depending upon various conditions such as the kind of sintering preventive, the pH value thereof in an aqueous alkali solution and the heating temperature, it is usually not more than 10 wt%, preferably 0.05 to 10 wt% based on the total weight of the particles.

As the sintering preventive, sintering preventives generally used are usable. For example, phosphorus compounds such as sodium hexametaphosphate, polyphosphoric acid and orthophosphoric acid; silicon compounds such as #3 water glass, sodium orthosilicate, sodium metasilicate and colloidal silica; boron compounds such as boric acid; aluminum compounds including aluminum salts such as aluminum acetate, aluminum sulfate, aluminum chloride and aluminum nitride, alkali aluminate such as sodium aluminate, and alumina sol and aluminum hydroxide; and titanium compounds such as titanyl sulfate may be exemplified.

The low-density acicular hematite particles obtained by heat-treating the acicular goethite particles coated with a sintering preventive at a temperature of 250 to 500°C have an average major axial diameter of usually 0.005 to 0.30  $\mu\text{m}$ , an average minor axial diameter of usually 0.0025 to 0.15  $\mu\text{m}$ , a BET specific surface area of usually about 70 to 350  $\text{m}^2/\text{g}$  and contain soluble sodium salts of usually 500 to 2000 ppm soluble sodium (calculated as Na) and soluble sulfates of usually 300 to 4000 ppm soluble sulfate (calculated as  $\text{SO}_4$ ). When the temperature for heat-treating the goethite particles is less than 250°C, the dehydration reaction takes a long time. On the other hand, When the tem-

perature exceeds 500°C, the dehydration reaction is abruptly brought out, so that it is difficult to retain the shapes because the sintering between particles is caused. The low-density acicular hematite particles obtained by heat-treating the goethite particles at a low temperature are low-density particles having a large number of dehydration pores through which H<sub>2</sub>O is removed from the goethite particles and the BET specific surface area thereof is about 1.2 to 2 times larger than that of the acicular goethite particles as the starting material.

The low-density hematite particles are then heat-treated at a temperature of not less than 550°C to obtain a high-density acicular hematite particles. The upper limit of the heating temperature is preferably 850°C. The high-density hematite particles contain soluble sodium salts of usually 500 to 4000 ppm soluble sodium (calculated as Na) and soluble sulfates of usually 300 to 5000 ppm soluble sulfate (calculated as SO<sub>4</sub>), and the BET specific surface area thereof is usually about 35 to 150 m<sup>2</sup>/g.

When the heat-treating temperature is less than 550°C, since the densification is insufficient, a large number of dehydration pores exist within and on the surface of the hematite particles, so that the dispersion in the vehicle is insufficient. Further, when the non-magnetic undercoat layer is formed from these particles, it is difficult to obtain a coated film having a smooth surface. On the other hand, when the temperature exceeds 850°C, although the densification of the hematite particles is sufficient, since sintering is caused on and between particles, the particle size increases, so that it is difficult to obtain a coated film having a smooth surface.

The obtained acicular hematite particles are pulverized by a dry-process, and formed into a slurry. The obtained slurry is then pulverized by a wet-process so as to deagglomerate coarse particles. In the wet-pulverization, ball mill, sand grinder, colloid mill or the like is used and wet-pulverization is conducted until coarse particles having a particle size of at least 44 µm are substantially removed. That is, the wet-pulverization is carried out until the amount of the coarse particles having a particle size of not less than 44 µm becomes to usually not more than 10% by weight, preferably not more than 5 % by weight, more preferably 0 % by weight based on the total weight of the particles. When the amount of the coarse particles having a particle size of not less than 44 µm is more than 10% by weight, the effect of treating the particles in an aqueous alkali solution at the next step is not attained.

The acicular hematite particles with coarse particles removed therefrom are heat-treated in a slurry at a temperature of usually not less than 80°C after the pH value of the slurry is adjusted to not less than 13 by adding an aqueous alkali solution such as sodium hydroxide.

The concentration of the alkali suspension containing the acicular hematite particles and having a pH value of not less than 13 is preferably 50 to 250 g/liter.

When the pH value of the alkali suspension containing the acicular hematite particles is less than 13, it is impossible to effectively remove the solid crosslinking caused by the sintering preventive which exists on the surfaces of the hematite particles, so that it is impossible to wash out the soluble sodium salt, soluble sulfate, etc. existing within and on the surfaces of the particles. The upper limit of the pH value is usually about 14. When the effect of removing the solid crosslinking caused by the sintering preventive which exists on the surfaces of the hematite particles, the effect of washing out the soluble sodium salt, soluble sulfate, etc., and the effect of removing the alkali which adheres to the surfaces of hematite particles in the process of the heat-treatment of the aqueous alkali suspension are taken into consideration, the preferable pH value thereof is in the range of 13.1 to 13.8.

The heat-treating temperature in the aqueous alkali suspension which contains the acicular hematite particles and has a pH value of not less than 13, is usually not less than 80°C, preferably not less than 90°C. If the temperature is less than 80°C, it is difficult to effectively remove the solid crosslinking caused by the sintering preventive which exists on the surfaces of the hematite particles. The upper limit of the heating temperature is preferably 103°C, more preferably 100°C. When the heating temperature exceeds 103°C, although it is possible to effectively remove the solid crosslinking, since an autoclave or the like is necessary or solution boils under a normal pressure, it is not advantageous from the point of view of industry.

The acicular hematite particles heat-treated in the aqueous alkali suspension are, thereafter, filtered out and washed with water by an ordinary method so as to remove the soluble sodium salt and soluble sulfate which are washed out of the interiors and the surfaces of the particles and the alkali such as sodium or the like adhered to the surfaces of the hematite particles in the process of heat-treatment with the aqueous alkali suspension, and then dried.

As the method of washing the particles with water, a method generally industrially used such as a decantation method, a dilution method using a filter thickener and a method of passing water into a filter press is adopted.

If the soluble sodium salt and soluble sulfate which are contained within the high-density hematite particles are washed out with water, even if soluble sodium salt and soluble sulfate adhere to the surfaces when the surfaces of the hematite particles are coated with a coating material in a subsequent step, for example, the later-described coating step, they can be easily removed by water-washing.

Alternatively, the high-density acicular hematite particles coated with the oxide of tin or the oxides of tin and antimony may be produced by the following method. That is, by using acicular goethite particles uncoated with the hydroxide of tin or the hydroxides of tin and antimony but coated with the sintering-preventive agent solely as a starting material, high-density acicular hematite particles uncoated with the hydroxide of tin or the hydroxides of tin and antimony are

first produced. The obtained high-density acicular hematite particles are heated in an aqueous alkaline solution, and then filtered and washed with water by ordinary methods. Next, the thus treated high-density acicular hematite particles are coated with the hydroxide of tin or the hydroxides of tin and antimony in the same manner as the above-mentioned coating-treatment of the acicular goethite particles. Thereafter, the high-density acicular hematite particles coated with the hydroxide of tin or the hydroxides of tin and antimony are heated at a temperature of usually not less than 300°C, preferably 350 to 850°C, to convert the hydroxide of tin or the hydroxides of tin and antimony on surfaces of the high-density acicular hematite particles, into the oxide of tin or the oxides of tin and antimony, thereby obtaining the high-density acicular hematite particles coated with the oxide of tin or the oxides of tin and antimony.

The high-density acicular hematite particles coated with the oxide of tin or the oxides of tin and antimony according to the present invention, may be further coated with at least one compound selected from the group consisting of a hydroxide of aluminum, an oxide of aluminum, a hydroxide of silicon and an oxide of silicon, if required.

In the coating-treatment, an aluminum compound, a silicon compound or both the aluminum and silicon compounds are added to a water suspension obtained by dispersing the high-density acicular hematite particles coated with the oxide of tin or the oxides of tin and antimony in an aqueous solution. The suspension is stirred and if required, the pH value of the suspension is adjusted properly to coat at least a part of the surface of the high-density acicular hematite particles with the hydroxide of aluminum, the oxide of aluminum, the hydroxide of silicon or the oxide of silicon. The suspension is then filtered to separate the coated high-density acicular hematite particles therefrom. The coated high-density acicular hematite particles is further washed with water, dried and pulverized. If required, the high-density acicular hematite particles may be subjected to deaeration, compaction or other treatments.

As the aluminum compound for the coating, the same aluminum compounds as those described above as the sintering preventive are usable.

The amount of aluminum compound added is usually 0.01 to 50.00 wt% (calculated as Al) based on the weight of the acicular hematite particles. When the amount is less than 0.01 wt%, the improvement of the dispersibility in the vehicle may be insufficient. On the other hand, if the amount exceeds 50.00 wt%, the coating effect becomes saturated, so that it is meaningless to add an aluminum compound more than necessary.

As the silicon compound, the same silicon compounds as those described above as the sintering preventive are usable.

The amount of silicon compound added is usually 0.01 to 50.00 wt% (calculated as SiO<sub>2</sub>) based on the weight of the acicular hematite particles. When the amount is less than 0.01 wt%, the improvement of the dispersibility in the vehicle may be insufficient. On the other hand, when the amount exceeds 50.00 wt%, the coating effect becomes saturated, so that it is meaningless to add an silicon compound more than necessary.

When both an aluminum compound and a silicon compound are used, the amount of thereof used is preferably 0.01 to 50.00 wt% (calculated as Al and SiO<sub>2</sub>) based on the weight of the acicular hematite particles.

It is important in the present invention that when the high-purity and high-density acicular hematite particles in which at least a part of the surface of the particle is coated with an oxide of tin or oxides of tin and antimony, and, which have an average major axial diameter of not more than 0.3 μm, a pH value of not less than 8, and which contain soluble sodium salts of not more than 300 ppm soluble sodium (calculated as Na) and soluble sulfates of not more than 150 ppm soluble sulfate (calculated as SO<sub>4</sub>), are used as the non-magnetic particles for a non-magnetic undercoat layer, it is possible to enhance the strength and the surface smoothness of the non-magnetic undercoat layer owing to the excellent dispersibility of the high-purity and high-density acicular hematite particles into a binder resin; and that when a magnetic recording medium is formed by using the non-magnetic undercoat layer, it is possible to reduce the light transmittance and the surface resistivity, to enhance the strength and to make the surface of the magnetic recording layer more smooth. Further, it is possible to suppress the deterioration in the magnetic properties which is caused by the corrosion of the acicular magnetic particles containing iron as a main ingredient dispersed in the magnetic recording layer.

The reason why the strength of the non-magnetic undercoat layer is enhanced and the surface of the non-magnetic undercoat layer is made more smooth, is considered to be as follows. Since it is possible to sufficiently remove the soluble sodium and the soluble sulfate, which agglomerate hematite particles by firmly crosslinking, by washing the particles with water, the agglomerates are separated into substantially discrete particles, so that acicular hematite particles having an excellent dispersion in the vehicle are obtained.

This fact will be explained in the following. The goethite particles as the starting material are produced by various methods, as described above. When as the raw material for producing acicular goethite particles ferrous sulfate is used in any method, a large amount of sulfate [SO<sub>4</sub><sup>2-</sup>] naturally exists in the goethite suspension.

Especially, when goethite particles are produced from an acidic solution, since water-soluble sulfate such as Na<sub>2</sub>SO<sub>4</sub> is simultaneously produced and an alkali metal such as K<sup>+</sup>, NH<sub>4</sub><sup>+</sup> and Na<sup>+</sup> are contained in the goethite suspension, a deposit containing an alkali metal and a sulfate is easily produced. This deposit is represented by RFe<sub>3</sub>(SO<sub>4</sub>)(OH)<sub>6</sub>, (R = K<sup>+</sup>, NH<sub>4</sub><sup>+</sup>, or Na<sup>+</sup>). Such a deposit is a slightly soluble sulfuric acid-containing salt and cannot be removed by an ordinary water-washing method. This slightly soluble salt becomes a soluble sodium salt or a soluble

sulfate in the next heat-treatment step. The soluble sodium salt and soluble sulfate are firmly combined with the interiors or the surfaces of the acicular hematite particles by a sintering preventive, which is essential for preventing the deformation of the acicular hematite particles and sintering between particles in the heat-treatment at a high temperature for the densification of the particles and which is crosslinking the acicular hematite particles. In this manner, agglomeration between acicular hematite particles becomes further firmer. As a result, the soluble sulfate and the soluble sodium salt, especially, imprisoned in the interiors of the particles or the agglomerates become very difficult to remove by an ordinary water-washing method.

When acicular goethite particles are produced in an aqueous alkali solution by using ferrous sulfate and sodium hydroxide,  $\text{Na}_2\text{SO}_4$  is simultaneously produced as a sulfate and  $\text{NaOH}$  exists in the goethite suspension. Since they are both soluble, if the acicular goethite particles are adequately washed with water,  $\text{Na}_2\text{SO}_4$  and  $\text{NaOH}$  ought to be removed. However, since the crystallinity of acicular goethite particles is generally small, the water-washing effect is poor, and when the particles are washed with water by an ordinary method, the particles still contain water-soluble contents such as a soluble sulfate  $[\text{SO}_4^{2-}]$  and a soluble sodium salt  $[\text{Na}^+]$ . The water-soluble contents are firmly combined with the interiors or the surfaces of the acicular hematite particles by the sintering preventive which is crosslinking the particles, as described above, and the agglomeration between acicular hematite particles becomes further firmer. As a result, the soluble sulfate and the soluble sodium salt, especially, imprisoned in the interiors of the particles or the agglomerates become very difficult to remove by an ordinary water-washing method.

It is considered that when the high-density acicular hematite particles in which the soluble sodium salt and the soluble sulfate are firmly combined with the interiors or the surfaces of the particles via the soluble sintering preventive, as described above, are pulverized by a wet-process so as to deagglomerate coarse particles, and heat-treated in the aqueous alkali solution having a pH value of not less than 13 at a temperature of not less than  $80^\circ\text{C}$ , the aqueous alkali solution sufficiently permeates into the interiors of the hematite particles, so that the binding strength of the sintering preventive which is firmly combined with the interiors and the surfaces of the particles, and the interiors of the agglomerates is gradually weakened, and the crosslinking is dissociated from the interiors and the surfaces of the particles and the interiors of the agglomerates, and simultaneously, the water-soluble sodium salt and the water-soluble sulfate are easily removed by water-washing.

It is considered that the deterioration in the magnetic properties which is caused by the corrosion of the acicular magnetic particles containing iron as a main ingredient, which are dispersed in the magnetic recording layer is suppressed because the contents of the soluble sodium salt and the soluble sulfate, which accelerate the corrosion of a metal, in the acicular hematite particles are small and the pH value of the hematite particles themselves is as high as not less than 8.

Actually, it is confirmed that a progress of corrosion of acicular magnetic particles containing iron as a main ingredient was suppressed by a synergistic effect of a small soluble content and a pH value of not less than 8, from the fact that the advantages of the present invention was not attained in any of the cases of (i) heat-treating the hematite particles after wet-pulverization in a slurry with the pH value adjusted to less than 13 at a temperature of not less than  $80^\circ\text{C}$ , (ii) heat-treating the hematite particles in a slurry with the pH value adjusted to not less than 13 at a temperature of less than  $80^\circ\text{C}$ , or (iii) heat-treating the hematite particles containing coarse particles without being pulverized by a wet-process in a slurry with the pH value adjusted to not less than 13 at a temperature of not less than  $80^\circ\text{C}$ , as shown in later-described examples and comparative examples.

By using the high-density acicular hematite particles according to the present invention, a non-magnetic undercoat layer having an excellent surface smoothness and a uniform thickness because of their excellent dispersibility in vehicle, as described above, can be obtained, and a mechanical strength of a substrate when the non-magnetic undercoat layer is formed thereon can be improved. Accordingly, the high-density acicular hematite particles according to the present invention can be suitably used as non-magnetic particles for non-magnetic undercoat layer.

Further, by using the non-magnetic undercoat layer according to the present invention, it becomes possible to form thereon a magnetic recording layer having an excellent surface smoothness and a uniform thickness due to its excellent properties described above. Accordingly, the non-magnetic undercoat layer according to the present invention can be suitably used as a non-magnetic undercoat layer of a magnetic recording medium for high-density recording.

Furthermore, the magnetic recording medium according to the present invention can exhibit a low transmittance and a low surface resistivity, because the high-density acicular hematite particles used therein have an excellent dispersibility in vehicle, and are coated with an oxide of tin or oxides of tin and antimony. In addition, since the high-density acicular hematite particles have a less soluble sodium salt content, a less soluble sulfate content and a pH value of not less than 8, acicular magnetic particles containing iron as a main ingredient, dispersed in a magnetic recording layer of the magnetic recording medium, can be prevented from being corroded, thereby inhibiting the deterioration in magnetic properties of the magnetic recording layer. Accordingly, the magnetic recording medium according to the present invention can maintain its excellent properties for a long period of time.

EXAMPLES

The present invention is described in more detail by Examples and Comparative Examples, but the Examples are only illustrative and, therefore, not intended to limit the scope of this invention.

Various properties of the high-density acicular particles, non-magnetic undercoat layer and magnetic recording medium according to the present invention were evaluated by the following methods.

(1) The residue on sieve after the wet-pulverization was obtained by measuring the concentration of the slurry after pulverization by a wet-process in advance, and determining the quantity of the solid content on the sieve remaining after the slurry equivalent to 100 g of the solid content was passed through the sieve of 325 meshes (mesh size: 44  $\mu\text{m}$ ).

(2) The average major axial diameter and the average minor axial diameter of the particles are expressed by the average values of 350 particles measured in the photograph obtained by magnifying an electron micrograph ( $\times 30000$ ) by 4 times in the vertical and horizontal directions, respectively. The aspect ratio is the ratio of the average major axial diameter and the average minor axial diameter.

(3) The geometrical standard deviation ( $\sigma_g$ ) of particle size distribution of the major axial diameter was obtained by the following method. The major axial diameters of the particles were measured from the magnified electron microphotograph in the above-mentioned (2). The actual major axial diameters of the particles and the number of particles were obtained from the calculation on the basis of the measured values. On logarithmico-normal probability paper, the major axial diameters were plotted at regular intervals on the abscissa-axis and the accumulative number of particles belonging to each interval of the major axial diameters was plotted by percentage on the ordinate-axis by a statistical technique. The major axial diameters corresponding to the number of particles of 50% and 84.13%, respectively, were read from the graph, and the geometrical standard deviation ( $\sigma_g$ ) was measured from the following formula:

$$\text{Geometrical standard deviation } (\sigma_g) = \{ \text{major axial diameter } (\mu\text{m}) \text{ corresponding to 84.13 \% under integration sieve} \} / \{ \text{major axial diameter (geometrical average diameter) corresponding to 50\% under integration sieve} \}.$$

The smaller the geometrical standard deviation, the more excellent the particle size distribution of the major axial diameters of the particles.

(4) The specific surface area is expressed by the value measured by a BET method.

(5) The degree of denseness of the particles is represented by  $S_{\text{BET}}/S_{\text{TEM}}$  as described above. The  $S_{\text{BET}}$  is a specific surface area measured by the above-described BET method. The  $S_{\text{TEM}}$  is a value calculated from the average major axial diameter  $d$  cm and the average minor axial diameter  $w$  cm measured from the electron microphotograph described in (2) on the assumption that a particle is a rectangular parallelepiped in accordance with the following formula:

$$S_{\text{TEM}} (\text{m}^2/\text{g}) = \{ (4 \cdot d \cdot w + 2w^2) / (d \cdot w^2 \cdot \rho_p) \} \times 10^{-4}$$

wherein  $\rho_p$  is the true specific gravity of the hematite particles, and 5.2 g/cm<sup>3</sup> was used.

Since  $S_{\text{TEM}}$  is a specific surface area of a particle having a smooth surface without any dehydration pore within or on the surface thereof, the closer  $S_{\text{BET}}/S_{\text{TEM}}$  of particles is to 1, it means, the smoother surface the particles have without any dehydration pore within or in the surface thereof, in other words, the particles are high-density particles.

(6) The content of each of Sn, Sb, Al, Co, P and Si was measured from fluorescent X-ray analysis.

(7) The pH value of the particles was measured in the following method. 5g of the sample was weighed into a 300-ml triangle flask, and 100 ml of pure water was added. The suspension was heated and after keeping the boiled state for 5 minutes, it was corked and left to cool to an ordinary temperature. After adding pure water which was equivalent to the pure water lost by boiling, the flask was corked again, shaken for 1 minute, and left to stand for 5 minutes. The pH value of the supernatant obtained was measured in accordance JIS Z 8802-7.

(8) The contents of soluble sodium salts and soluble sulfates were measured by measuring the Na content and  $\text{SO}_4^{2-}$  content in the filtrate obtained by filtering the supernatant liquid produced for the measurement of pH value which is described above through filter paper No. 5C, by using an Inductively Coupled Plasma Emission Spectrophotometer (manufactured by Seiko Instruments and Electronics, Ltd.).

(9) The volume resistivity of acicular hematite particles was measured as follows. First, 0.5 g of acicular hematite particles were weighed and pressure-molded under  $140 \text{ kg/cm}^2$  by KBr pellet molding apparatus (manufactured by Simazu Seisakusho Co., Ltd.) to form a cylindrical sample.

Next, the cylindrical sample was allowed to stand at a temperature of  $25^\circ\text{C}$  and a relative humidity (RH) of 60 % for not less than 12 hours. The sample was set between stainless steel electrodes, and impressed with a voltage of 15 V using a Wheatstone bridge "TYPE 2768" (manufactured by Yokogawa Hokushin Denki Co., Ltd.) to measure a resistance ( $\Omega$ ) thereof.

Next, the sample was measured for a upper surface area A ( $\text{cm}^2$ ) and a thickness t (cm) thereof. A volume resistivity X ( $\Omega\text{-cm}$ ) is obtained by the following formula:

$$X (\Omega\text{-cm}) = R \times (A/t)$$

wherein R represents an actual measured value of resistance.

(10) The surface resistivity of a coating film was measured as follows. The coating film was first allowed to stand at a temperature of  $25^\circ\text{C}$  and a relative humidity (RH) of 60 % for not less than 12 hours. Thereafter, the coating film which was slit into a width of 6 mm, and was disposed between metal electrodes each having a width of 6.5 mm, such that a coating surface of the coating film was contacted with these electrodes. 170 g of weights were respectively fixed to opposite ends of the coating film so as to bring the coating surface of the coating film into close contact with the electrodes. Thereafter, D.C. voltage of 500 V was applied between the metal electrodes to measure a surface resistivity of the coating film by using a resistance meter Model 14329A (manufactured by Yokogawa Hewlett Packard Co., Ltd.).

(11) The viscosity of the coating composition was obtained by measuring the viscosity of the coating composition at  $25^\circ\text{C}$  at a shear rate D of  $1.92 \text{ sec}^{-1}$  by using an E type viscometer EMD-R (manufactured by Tokyo Keiki, Co., Ltd.).

(12) The gloss of the surface of the coating film of each of the non-magnetic undercoat layer and the magnetic recording layer was measured at an angle of incidence of  $45^\circ$  by a glossmeter UGV-5D (manufactured by Suga Shikenki, Co., Ltd.).

(13) The surface roughness  $R_a$  is expressed by the average value of the center-line average roughness of the profile curve of the surface of the coating film by using "Surfcom-575A" (manufactured by Tokyo Seimitsu Co., Ltd.).

(14) The strength of the non-magnetic undercoat layer and magnetic recording medium was expressed the Young's modulus obtained by "Autograph" (produced by Shimazu Seisakusho Ltd.). The Young's modulus was expressed by the ratio of the Young's modulus of the coating film to that of a commercially available video tape "AV T-120" (produce by Victor Company of Japan, Ltd.). The higher the relative value, the more favorable.

(15) The magnetic properties were measured under an external magnetic field of 10 kOe by "Vibration Sample Magnetometer VSM-3S-15" (manufactured by Toei Kogyo, Co., Ltd.).

(16) The change in the magnetic properties with passage of time of a magnetic recording medium caused by the corrosion of the magnetic particles containing iron as a main ingredient was examined as follows.

The magnetic recording medium was allowed to stand in an environment of a temperature of  $60^\circ\text{C}$  and a relative humidity of 90% for 14 days, and the coercive force and the saturation magnetic flux density were measured before and after standing. A change in each characteristic was divided by the value before standing, and represented by

percentage as a percentage of change.

(17) The light transmittance of a magnetic recording medium is expressed by the linear adsorption coefficient using a light transmittance at  $\lambda = 900$  nm measured by "Photoelectric Spectrophotometer UV-2100" (manufactured by Shimadzu Seisakusho, Ltd.). The linear adsorption coefficient is defined by the following formula:

$$\text{Linear adsorption coefficient } (\mu\text{m}^{-1}) = \{1n(1/t)\}/FT$$

wherein  $t$  represents light transmittance (-) at  $\lambda = 900$  nm, and  $FT$  represents thickness ( $\mu\text{m}$ ) of the coating film composition of the film used for the measurement.

The larger the value, the more difficult it is for the magnetic recording medium to transmit light.

As a blank for measuring the linear adsorption coefficient, the same non-magnetic substrate as that of the above-mentioned magnetic recording medium, was used.

(18) The thickness of each of the non-magnetic substrate, the non-magnetic undercoat layer and the magnetic recording layer constituting the magnetic recording medium was measured in the following manner by using a Digital Electronic Micrometer K351C (manufactured by Anritsu Denki Corp.)

The thickness (A) of a non-magnetic substrate was first measured. Similarly, the thickness (B) (B = the sum of the thicknesses of the non-magnetic substrate and the non-magnetic undercoat layer) of a substrate obtained by forming a non-magnetic undercoat layer on the non-magnetic substrate was measured. Furthermore, the thickness (C) (C = the sum of the thicknesses of the non-magnetic substrate, the non-magnetic undercoat layer and the magnetic recording layer) of a magnetic recording medium obtained by forming a magnetic recording layer on the non-magnetic undercoat layer was measured. The thickness of the non-magnetic undercoat layer is expressed by  $B - A$ , and the thickness of the magnetic recording layer is expressed by  $C - B$ .

#### Example 1

##### <Production of acicular hematite particles>

#### Example 1:

1,200 g of spindle-shaped goethite particles obtained by the afore-mentioned goethite production method (B) (average major axial diameter: 0.178  $\mu\text{m}$ , average minor axial diameter: 0.0225  $\mu\text{m}$ , aspect ratio: 7.91:1, BET specific surface area: 160.3  $\text{m}^2/\text{g}$ , soluble sodium salt content: 1232 ppm (calculated as Na), soluble sulfate content: 621 ppm (calculated as  $\text{SO}_4$ ), pH value: 6.7 and geometrical standard deviation: 1.33) were suspended in a mixed solution of an aqueous ferrous sulfate solution and an aqueous sodium carbonate solution to form a slurry having a solid content of 8 g/liter. After 150 liters of the slurry was heated to 60°C, a 0.1N NaOH aqueous solution was added thereto to adjust the pH value to 9.0.

Next, 2,022 ml of an aqueous solution containing 0.5 mol/liter of sodium stannate was gradually added to the thus obtained alkaline slurry. After completion of the addition, a 0.8N acetic acid solution was added to the slurry to adjust the pH value to 7.5. Thereafter, the slurry was successively filtered, washed with water, dried and pulverized by ordinary methods to obtain spindle-shaped goethite particles whose surfaces were coated with a hydroxide of tin. It was confirmed that the amount of the hydroxide of tin was 9.32 % by weight (calculated as Sn) based on the weight of the spindle-shaped goethite particles.

1,000 g of the thus obtained spindle-shaped goethite particles coated with the hydroxide of tin, were charged into a stainless steel rotary furnace, and heat-dehydrated in air at 350°C for 60 minutes while rotating the furnace, thereby obtaining low-density spindle-shaped hematite particles coated with an oxide of tin. It was determined that the thus obtained low-density spindle-shaped hematite particles had an average major axial diameter of 0.134  $\mu\text{m}$ , an average minor axial diameter of 0.0194  $\mu\text{m}$ , an aspect ratio (average major axial diameter/average minor axial diameter) of 6.91:1, a BET specific surface area ( $S_{\text{BET}}$ ) of 168.3  $\text{m}^2/\text{g}$ , a degree of densification ( $S_{\text{BET}}/S_{\text{STEM}}$ ) of 3.96, a soluble sodium salt content of 1123 ppm (calculated as Na), a soluble sulfate content of 465 ppm (calculated as  $\text{SO}_4$ ), a pH value of 6.3, a geometrical standard deviation of 1.34 and a volume resistivity of  $1.1 \times 10^6 \Omega\text{cm}$ . Further, the amount of the oxide of tin was 10.60 % by weight (calculated as Sn) based on the weight of the spindle-shaped hematite particles.

Next, 900 g of the low-density spindle-shaped hematite particles were charged into a ceramic rotary furnace, and

heated in air at 650°C for 20 minutes while rotating the furnace to seal dehydrating pores of the particles, thereby obtaining high-density spindle-shaped hematite particles coated with the oxide of tin. It was determined that the obtained high-density spindle-shaped hematite particles had an average major axial diameter of 0.129  $\mu\text{m}$ , an average minor axial diameter of 0.0206  $\mu\text{m}$ , an aspect ratio (average major axial diameter/average minor axial diameter) of 6.26:1, a BET specific surface area ( $S_{\text{BET}}$ ) of 46.6  $\text{m}^2/\text{g}$ , a degree of high densification ( $S_{\text{BET}}/S_{\text{STEM}}$ ) of 1.16, a soluble sodium salt content of 2864 ppm (calculated as Na), a soluble sulfate content of 2956 ppm (calculated as  $\text{SO}_4$ ), a pH value of 5.4, a geometrical standard deviation of 1.36 and a volume resistivity of  $9.6 \times 10^5 \Omega\text{cm}$ . Further, the amount of the oxide of tin was 10.72 % by weight (calculated as Sn) based on the weight of the spindle-shaped hematite particles.

After 800 g of the high-density spindle-shaped hematite particles obtained were roughly pulverized by a Nara mill in advance, the obtained particles were charged into 4.7 liters of pure water and peptized by a homomixer (manufactured by Tokushu-kika Kogyo, CO., Ltd.) for 60 minutes.

The slurry of the high-density spindle-shaped hematite particles obtained was then mixed and dispersed for 3 hours at an axial rotation frequency of 2000 rpm while being circulated by a horizontal SGM (Dispermat SL, manufactured by S.C. Adichem, CO., Ltd.). The spindle-shaped hematite particles in the slurry remaining on a sieve of 325 meshes (mesh size: 44  $\mu\text{m}$ ) was 0 % by weight.

The concentration of the high-density spindle-shaped hematite particles in the slurry was adjusted to 100 g/liter, and a 6N-aqueous NaOH solution was added to 7 liter of the slurry under stirring so as to adjust the pH value to 13.3. The slurry was then heated to 95°C under stirring, and was held for 3 hours at 95°C.

The slurry was then washed with water by a decantation method and the pH value of the slurry was adjusted to 10.5. When the concentration of the slurry at this point was checked so as to ensure the accuracy, it was 96 g/liter.

2 liter of the slurry washed with water was filtered through a Buchner filter, and pure water was passed until the electric conductivity of the filtrate became not more than 30  $\mu\text{S}$ . The particles were then dried by an ordinary method and pulverized so as to obtain the target high-density spindle-shaped hematite particles. The high-density spindle-shaped hematite particles obtained contained 10.83 wt% of an oxide of tin (calculated as Sn), and had an average major axial diameter of 0.128  $\mu\text{m}$ , a minor axial diameter of 0.0206  $\mu\text{m}$ , an aspect ratio of 6.71:1, a geometric standard deviation  $\sigma$  of particle size (major axial diameter) of 1.35, a BET specific surface ( $S_{\text{BET}}$ ) of 47.1  $\text{m}^2/\text{g}$ , a  $S_{\text{BET}}/S_{\text{STEM}}$  value of densification of 1.17 and a pH value of the particles of 8.9. The spindle-shaped hematite particles contained soluble sodium salts of 112 ppm soluble sodium (calculated as Na) and soluble sulfates of 41 ppm soluble sulfate (calculated as  $\text{SO}_4$ ). The volume resistivity thereof was  $6.3 \times 10^6 \Omega\text{cm}$ .

## Example 2

### <Production of a non-magnetic undercoat layer>

12 g of the high-density spindle-shaped hematite particles obtained in the Example 1 were mixed with a binder resin solution (30 wt% of vinyl chloride-vinyl acetate copolymer resin having a sodium sulfonate group and 70 wt% of cyclohexanone) and cyclohexanone, and the mixture (solid content: 72 wt%) obtained was kneaded by a plasto-mill for 30 minutes.

The thus-obtained kneaded material was charged into a 140 ml-glass bottle together with 95 g of 1.5 mm $\phi$  glass beads, a binder resin solution (30 wt% of polyurethane resin having a sodium sulfonate group and 70 wt% of a solvent (methyl ethyl ketone : toluene = 1 : 1)), cyclohexanone, methyl ethyl ketone and toluene, and the obtained mixture was mixed and dispersed by a paint shaker for 6 hours to obtain a coating composition.

The thus-obtained coating composition containing high-density spindle-shaped hematite particles was as follows:

High-density spindle-shaped hematite particles	100 parts by weight
Vinyl chloride-vinyl acetate copolymer resin having a sodium sulfonate group	10 parts by weight
Polyurethane resin having a sodium sulfonate group	10 parts by weight
Cyclohexanone	44.6 parts by weight
Methylethyl ketone	111.4 parts by weight
Toluene	66.9 parts by weight

The coating composition obtained containing high-density spindle-shaped hematite particles was applied to a polyethylene terephthalate film of 12  $\mu\text{m}$  thick to a thickness of 55  $\mu\text{m}$  by an applicator, and the film was then dried, thereby forming a non-magnetic undercoat layer. The thickness of the non-magnetic undercoat layer was 3.5  $\mu\text{m}$ .

The gloss of the coating film of the obtained non-magnetic undercoat layer was 201%, the surface roughness Ra was 6.8 nm, and the Young's modulus (relative value) was 128.

### Example 3

#### <Production of a magnetic recording layer>

12 g of spindle-shaped magnetic particles containing iron as a main ingredient (average major axial diameter: 0.104  $\mu\text{m}$ , average minor axial diameter: 0.0158  $\mu\text{m}$ , aspect ratio: 6.58:1, coercive force: 1905 Oe, saturation magnetization: 138 emu/g, Al content: 4.41 wt%, and Co content: 5.51 wt%), 1.2 g of a polishing agent (AKP-50: trade name, produced by Sumitomo Chemical Co., Ltd.), 0.36 g of carbon black (#3250B, trade name, produced by Mitsubishi Chemical Corp.), a binder resin solution (30 wt% of vinyl chloride-vinyl acetate copolymer resin having a sodium sulfonate group and 70 wt% of cyclohexanone) and cyclohexanone were mixed to obtain a mixture (solid content: 78 wt%). The mixture was further kneaded by a plasto-mill for 30 minutes to obtain a kneaded material.

The thus-obtained kneaded material was charged into a 140 ml-glass bottle together with 95 g of 1.5 mm $\phi$  glass beads, a binder resin solution (30 wt% of polyurethane resin having a sodium sulfonate group and 70 wt% of a solvent (methyl ethyl ketone : toluene = 1 : 1)), cyclohexanone, methyl ethyl ketone and toluene, and the mixture was mixed and dispersed by a paint shaker for 6 hours. Thereafter, the lubricant and hardening agent were added to the resultant mixture, and then the obtained mixture was mixed and dispersed by paint shaker for 15 minutes.

The thus-obtained magnetic coating composition was as follows:

Magnetic particles containing iron as a main ingredient	100 parts by weight
Vinyl chloride-vinyl acetate copolymer resin having a sodium sulfonate group	10 parts by weight
Polyurethane resin having a sodium sulfonate group	10 parts by weight
Polishing agent (AKP-50)	10 parts by weight
Carbon black (#3250B)	3.0 parts by weight
Lubricant (myristic acid: butyl stearate = 1 : 2)	3.0 parts by weight
Hardening agent (polyisocyanate)	5.0 parts by weight
Cyclohexanone	65.8 parts by weight
Methyl ethyl ketone	164.5 parts by weight
Toluene	98.7 parts by weight

The magnetic coating composition obtained was applied to the non-magnetic undercoat layer to a thickness of 15  $\mu\text{m}$  by an applicator, and the magnetic recording medium obtained was oriented and dried in a magnetic field, and then calendered. The magnetic recording medium was then subjected to a curing reaction at 60°C for 24 hours, and thereafter slit into a width of 0.5 inch, thereby obtaining a magnetic tape. The thickness of the magnetic recording layer was 1.1  $\mu\text{m}$ .

The magnetic tape obtained had a coercive force of 1986 Oe, a squareness (Br/Bm) of 0.87, a gloss of 228%, a surface roughness Ra of 6.4 nm, a Young's modulus (relative value) of 133, a linear absorption coefficient of 1.21, a surface resistivity of  $1.1 \times 10^7 \Omega/\text{sq}$ . The changes in the coercive force and the saturation magnetic flux density Bm with passage of time were 6.4%, and 5.4%, respectively.

#### Examples 4 to 21, Comparative Examples 1 to 14

#### <Types of acicular goethite particles>

The starting materials A to F shown in Table 1 were used as the starting materials for producing acicular hematite particles.

<Production of low-density acicular hematite particles>

Low-density acicular hematite particles were obtained in the same way as in Example 1 except for varying the kind of acicular goethite particles as the starting materials, the kind and amount of tin compound, the kind and amount of antimony compound, the kind and amount of sintering preventive, and heat-dehydrating temperature and time.

The main producing conditions and various properties are shown in Tables 2 to 3.

Examples 22 to 39, Comparative Examples 15 to 27<Production of high-density acicular hematite particles>

High-density acicular hematite particles were obtained in the same way as in Example 1 except for varying the kind of low-density hematite particles, and the heating temperature and time for densification.

The main producing conditions and various properties are shown in Tables 4 and 5.

Examples 40 to 57, Comparative Examples 28 to 35<Treatment of acicular hematite particles in an aqueous alkali solution>

High-purity, high-density acicular hematite particles were obtained in the same way as in Example 1 except for varying the kind of high-density acicular hematite particles, whether or not the wet-pulverization process was conducted, whether or not the heat-treatment in the aqueous alkali solution was conducted, the pH value of the slurry, and the heating time and temperature.

The main producing conditions and various properties are shown in Tables 6 to 9.

Example 58<Surface coating of acicular hematite particles>

The concentration of the slurry having a pH value 10.5 which was obtained in Example 40 by washing the particles in an aqueous alkali solution after heat-treatment with water by a decantation method was 96 g/liter. 5 liter of the slurry was re-heated to 60°C, and 231 ml (equivalent to 1.3 wt% (calculated as Al) based on the acicular hematite particles) of a 1.0-N NaAlO<sub>2</sub> solution was added to the slurry, and the mixture was held for 60 minutes. Thereafter, the pH value of the mixture was adjusted to 8.2 by using acetic acid. The particles were then filtered out, washed with water, dried and pulverized in the same way as in Example 1, thereby obtaining acicular hematite particles coated with a coating material.

The main producing conditions and various properties are shown in Tables 10 and 11.

Examples 59 to 72

Acicular hematite particles coated with a coating material were obtained in the same way as in Example 58 except for varying the kind of acicular hematite particles, and the kind and the amount of surface treating material.

The main producing conditions and various properties are shown in Table 10 and 11.

Example 73:

<Coating-treatment of high-density acicular hematite particles treated with alkaline aqueous solution, with oxide of tin or oxides of tin and antimony>

The slurry obtained in Example 55 by washing with water by a decantation method after the heat-treatment in alkaline aqueous solution, had a pH value of 10.5 and a concentration of 96 g/liter. After 5 liters of the slurry was heated again to 60°C, 121 ml of a 1.0-mol sodium stannate solution (corresponding to 3.0 % by weight (calculated as Sn) based on the weight of the acicular hematite particles) was added thereto. After the slurry was allowed to stand for 60 minutes, the pH value thereof was adjusted to 8.0 by adding acetic acid thereto. Next, the slurry was filtered to separate a solid component therefrom, and then the solid component was washed with water, dried and pulverized in the same manner as in Example 1, thereby obtaining high-density acicular hematite particles coated with a hydroxide of tin.

The essential production conditions and properties of the obtained high-density acicular hematite particles are shown in Tables 10 and 11.

Examples 74 and 75:

The same procedure as defined in Example 73 was conducted except that kind of acicular hematite particles treated with alkaline aqueous solution, kind and amount of tin compound, kind, amount and use or non-use of antimony compound and treating temperature and treating time used for the heat-treatment were varied, thereby obtaining high-density acicular hematite particles coated with a hydroxide of tin or hydroxides of tin and antimony.

The essential production conditions and properties of the obtained high-density acicular hematite particles are shown in Tables 10 and 11.

Example 76:

The high-density acicular hematite particles coated with the hydroxide of tin which were obtained in Example 73, were charged into a stainless steel rotary furnace, and heated in air at 400°C for 60 minutes while rotating the furnace, thereby obtaining high-density acicular hematite particles coated with an oxide of tin.

The essential production conditions and properties of the obtained high-density acicular hematite particles are shown in Tables 12 and 13.

Examples 77 and 78:

The same procedure as defined in Example 76 was conducted except that kind of high-density acicular hematite particles coated with a hydroxide of tin or hydroxides of tin and antimony and treating temperature and treating time used for the heat-treatment were varied, thereby obtaining high-density acicular hematite particles coated with an oxide of tin or oxides of tin and antimony.

The essential production conditions and properties of the obtained high-density acicular hematite particles are shown in Tables 12 and 13.

Examples 79 to 111, Comparative Examples 36 to 50<Production of a non-magnetic undercoat layer>

A non-magnetic undercoat layer was obtained in the same way as in Example 2 by using the acicular hematite particles obtained in Examples 40 to 54, 58 to 72 and 76 to 78, Comparative Examples 1, 3, 15 to 18, 23 and 28 to 35.

The main producing conditions and various properties are shown in Tables 14 to 16.

Examples 112 to 144, Comparative Examples 51 to 65<Production of a magnetic recording medium using magnetic particles containing iron as a main ingredient>

A magnetic recording medium using acicular magnetic particles containing iron as a main ingredient was obtained in the same way as in Example 3 except for varying the kind of non-magnetic undercoat layer obtained in Examples 79 to 111 and Comparative Examples 36 to 50 and the kind of acicular magnetic particles containing iron as a main ingredient.

The main producing conditions and various properties are shown in Tables 17 to 19.

Table 1

Kind of starting material	Acicular Goethite particles		
	Production method	Average major axial diameter ( $\mu\text{m}$ )	Average minor axial diameter ( $\mu\text{m}$ )
Starting material A	BB	0.181	0.0246
Starting material B	BB	0.220	0.0283
Starting material C	DD	0.245	0.0305
Starting material D	CC	0.164	0.0218
Starting material E	AA	0.260	0.0298
Starting material F	BB	0.234	0.0288

Table 1 (continued)

Kind of starting material	Acicular Goethite particles		
	Aspect ratio* (-)	Geometrical standard deviation $\sigma_g$ (-)	BET specific surface area ( $\text{m}^2/\text{g}$ )
Starting material A	7.36	1.37	151.0
Starting material B	7.77	1.34	125.0
Starting material C	8.03	1.31	95.1
Starting material D	7.52	1.37	186.5
Starting material E	8.72	1.44	72.6
Starting material F	8.13	1.31	110.5

(Note) \*: Aspect ratio - average major axial diameter/  
average minor axial diameter

Table 1 (continued)

Kind of starting material	Acicular Goethite particles		
	Soluble sodium salt (ppm)	Soluble sulfate (ppm)	pH value (-)
Starting material A	412	386	6.8
Starting material B	512	264	7.2
Starting material C	1215	2150	5.1
Starting material D	415	915	5.5
Starting material E	1565	171	8.3
Starting material F	436	312	6.9

(Note) PRODUCTION METHOD:

AA: A method of oxidizing a suspension having a pH value of not less than 11 and containing colloidal ferrous hydroxide particles which is obtained by adding not less than an equivalent of an alkali hydroxide solution to an aqueous ferrous salt solution, by passing an oxygen-containing gas thereinto at a temperature of not higher than 80°C.

BB: A method of producing acicular goethite particles by oxidizing a suspension containing  $\text{FeCO}_3$  which is obtained by reacting an aqueous ferrous salt solution with an aqueous alkali carbonate solution, by passing an oxygen-containing gas thereinto after aging the suspension, if necessary.

CC: A method of growing acicular seed goethite  
particles by oxidizing a ferrous hydroxide solution  
5 containing colloidal ferrous hydroxide particles which is  
obtained by adding less than an equivalent of an alkali  
10 hydroxide solution or an alkali carbonate solution to an  
aqueous ferrous salt solution, by passing an oxygen-  
15 containing gas thereinto, thereby producing acicular seed  
goethite particles, adding not less than an equivalent of an  
alkali hydroxide solution to the  $\text{Fe}^{2+}$  in the aqueous ferrous  
20 salt solution, to the aqueous ferrous salt solution  
containing the acicular goethite seed particles, and passing  
25 an oxygen-containing gas into the aqueous ferrous salt  
solution.

30 DD: A method of growing acicular seed goethite  
particles by oxidizing a ferrous hydroxide solution  
containing colloidal ferrous hydroxide particles which is  
35 obtained by adding less than an equivalent of an alkali  
hydroxide solution or an alkali carbonate solution to an  
40 aqueous ferrous salt solution, by passing an oxygen-  
containing gas thereinto, thereby producing acicular seed  
goethite particles, and growing the obtained acicular seed  
45 goethite particles in an acidic or neutral region.

Table 2

Examples	Kind of acicular goethite particles as the starting material	Sintering preventive		
		Kind	Calculated as	Amount added (wt. %)
Example 4	Particles of Example 1	Sodium stannate	Sn	15.0
Example 5	Starting material A	Stannous chloride	Sn	20.0
Example 6	Starting material A	Sodium stannate #3 Water glass	Sn SiO <sub>2</sub>	50.0 1.0
Example 7	Starting material B	Sodium stannate	Sn	1.2
Example 8	Starting material B	Sodium stannate	Sn	3.0
Example 9	Starting material C	Stannous chloride	Sn	10.0
Example 10	Starting material C	Sodium stannate	Sn	50.0
Example 11	Starting material D	Sodium stannate	Sn	200.0
Example 12	Starting material D	Sodium stannate	Sn	500.0
Example 13	Starting material E	Stannous chloride	Sn	100.0
Example 14	Starting material E	Sodium stannate Phosphoric acid	Sn P	75.0 0.5
Example 15	Starting material F	Sodium stannate Antimony chloride	Sn Sb	50.0 5.0
Example 16	Starting material F	Sodium stannate Antimony acetate	Sn Sb	10.0 2.0
Example 17	Particles of Example 1	Sodium stannate Antimony sol #3 Water glass	Sn Sb SiO <sub>2</sub>	100.0 10.0 1.5
Example 18	Particles of Example 1	Stannous chloride Antimony chloride Aluminum sulfate	Sn Sb Al	300.0 15.0 1.0
Example 19	Starting material A	Sodium hexametaphosphate	P	1.5
Example 20	Starting material A	#3 Water glass	SiO <sub>2</sub>	2.0
Example 21	Starting material A	Phosphoric acid #3 Water glass	P SiO <sub>2</sub>	0.5 0.75

Table 2 (continued)

Examples	Heat treatment for low densification		Low-density acicular hematite particles	
	Temperature (°C)	Time (min)	Average major axial diameter (μm)	Average minor axial diameter (μm)
Example 4	300	90	0.138	0.0199
Example 5	350	30	0.143	0.0214
Example 6	330	120	0.140	0.0221
Example 7	280	30	0.180	0.0261
Example 8	300	60	0.183	0.0260
Example 9	330	120	0.200	0.0277
Example 10	350	90	0.206	0.0290
Example 11	380	60	0.138	0.0211
Example 12	400	30	0.140	0.0240
Example 13	380	60	0.218	0.0283
Example 14	380	90	0.213	0.0276
Example 15	350	60	0.191	0.0277
Example 16	375	60	0.192	0.0278
Example 17	310	240	0.142	0.0205
Example 18	350	180	0.145	0.0211
Example 19	330	60	0.141	0.0213
Example 20	310	90	0.141	0.0210
Example 21	350	120	0.144	0.0278

Table 2 (continued)

Examples	Low-density acicular hematite particles			
	Geometrical standard deviation $\sigma_g$ (-)	Aspect ratio* (-)	$S_{BET}$ ( $m^2/g$ )	$S_{STEM}$ ( $m^2/g$ )
Example 4	1.33	6.93	169.1	41.4
Example 5	1.37	6.68	168.5	38.6
Example 6	1.38	6.33	160.8	37.6
Example 7	1.34	6.90	144.0	31.6
Example 8	1.34	7.04	135.9	31.7
Example 9	1.33	7.22	119.0	29.7
Example 10	1.32	7.10	125.1	28.4
Example 11	1.37	6.54	197.5	39.2
Example 12	1.40	5.83	213.5	34.8
Example 13	1.44	7.70	110.8	28.9
Example 14	1.44	7.72	103.6	29.7
Example 15	1.32	6.90	146.9	29.8
Example 16	1.32	6.91	138.5	29.7
Example 17	1.34	6.93	173.8	40.2
Example 18	1.34	6.87	180.6	39.1
Example 19	1.36	6.62	171.6	38.8
Example 20	1.36	6.71	178.8	39.4
Example 21	1.36	6.92	186.2	39.7

(Note) \*: Aspect ratio = average major axial diameter/  
average minor axial diameter

Table 2 (continued)

Examples	Low-density acicular hematite particles			
	$S_{\text{BET}} / S_{\text{TEM}}$ (-)	Soluble sodium salt (ppm)	Soluble sulfare (ppm)	pH value (-)
Example 4	4.08	1263	680	7.8
Example 5	4.36	1897	879	7.1
Example 6	4.28	1835	980	8.1
Example 7	4.56	870	789	6.5
Example 8	4.29	1123	987	6.8
Example 9	4.01	2356	1234	6.3
Example 10	4.41	2987	1145	6.8
Example 11	5.03	3456	789	7.9
Example 12	6.14	4890	891	8.0
Example 13	3.83	2156	1348	6.5
Example 14	3.49	1768	1123	7.5
Example 15	4.93	1345	888	6.0
Example 16	4.67	1879	1334	6.1
Example 17	4.32	2350	1345	8.1
Example 18	4.62	2879	789	7.3
Example 19	4.42	2006	912	7.5
Example 20	4.54	2128	986	7.3
Example 21	4.70	2166	982	7.3

Table 3

Comparative Examples	Kind of acicular goethite particles as the starting particles	Sintering preventive		
		Kind	Calculated as	Amount added (wt. %)
Comparative Example 1	Particles of Example 1	-	-	-
Comparative Example 2	Particles of Example 1	-	-	-
Comparative Example 3	Particles of Example 1	#3 Water glass	SiO <sub>2</sub>	0.50
Comparative Example 4	Particles of Example 1	Phosphoric acid	P	0.50
Comparative Example 5	Particles of Example 1	#3 Water glass	SiO <sub>2</sub>	1.00
Comparative Example 6	Particles of Example 1	Sodium hexametaphosphate	P	0.50
Comparative Example 7	Particles of Example 1	#3 Water glass	SiO <sub>2</sub>	1.50
Comparative Example 8	Particles of Example 1	#3 Water glass	SiO <sub>2</sub>	0.20
Comparative Example 9	Particles of Example 1	Phosphoric acid	P	0.75
Comparative Example 10	Starting material F	Sodium hexametaphosphate	P	2.00
Comparative Example 11	Starting material F	#3 Water glass	SiO <sub>2</sub>	1.25
Comparative Example 12	Starting material F	Phosphoric acid	P	1.50
Comparative Example 13	Starting material F	Colloidal silica	SiO <sub>2</sub>	0.25
Comparative Example 14	Starting material F	Sodium stannate	Sn	0.05

Table 3 (continued)

Comparative Examples	Heat treatment for low densification		Low-density acicular hematite particles	
	Temperature (°C)	Time (min)	Average major axial diameter ( $\mu\text{m}$ )	Average minor axial diameter ( $\mu\text{m}$ )
Comparative Example 1	350	90	0.135	0.0199
Comparative Example 2	380	45	0.132	0.0206
Comparative Example 3	340	75	0.136	0.0197
Comparative Example 4	-	-	-	-
Comparative Example 5	350	60	0.134	0.0199
Comparative Example 6	350	30	0.132	0.0197
Comparative Example 7	330	90	0.134	0.0197
Comparative Example 8	300	60	0.132	0.0190
Comparative Example 9	380	20	0.132	0.0195
Comparative Example 10	380	90	0.193	0.0276
Comparative Example 11	350	90	0.193	0.0280
Comparative Example 12	330	30	0.192	0.0278
Comparative Example 13	325	45	0.189	0.0288
Comparative Example 14	300	60	0.185	0.0293

Table 3 (continued)

Comparative Examples	Low-density acicular hematite particles			
	Geometrical standard deviation $\sigma_g$ (-)	Aspect ratio* (-)	$S_{BET}$ (m <sup>2</sup> /g)	$S_{STEM}$ (m <sup>2</sup> /g)
Comparative Example 1	1.33	6.78	171.6	41.5
Comparative Example 2	1.34	6.41	135.8	40.3
Comparative Example 3	1.33	6.90	165.8	41.9
Comparative Example 4	-	-	-	-
Comparative Example 5	1.34	6.73	134.8	41.5
Comparative Example 6	1.35	6.70	125.9	42.0
Comparative Example 7	1.35	6.80	145.0	41.9
Comparative Example 8	1.35	6.95	145.9	43.4
Comparative Example 9	1.36	6.77	156.9	42.4
Comparative Example 10	1.33	6.99	124.3	29.9
Comparative Example 11	1.33	6.89	131.2	29.5
Comparative Example 12	1.32	6.91	138.2	29.7
Comparative Example 13	1.33	6.56	136.3	28.7
Comparative Example 14	1.32	6.31	126.4	28.3

(Note) \*: Aspect ratio = average major axial diameter/  
average minor axial diameter

Table 3 (continued)

Comparative Examples	Low-density acicular hematite particles				
	$S_{\text{BET}} / S_{\text{TEM}}$ (-)	Soluble sodium salt (ppm)	Soluble sulfate (ppm)	pH value (-)	Volume resistivity ( $\Omega\text{cm}$ )
Comparative Example 1	4.13	852	568	6.0	$1.2 \times 10^8$
Comparative Example 2	3.37	903	498	6.5	-
Comparative Example 3	3.96	1245	423	6.8	$4.0 \times 10^8$
Comparative Example 4	-	-	-	-	-
Comparative Example 5	3.25	1235	568	6.7	-
Comparative Example 6	3.00	1025	612	6.6	-
Comparative Example 7	3.46	1365	682	7.1	-
Comparative Example 8	3.36	1265	591	7.2	-
Comparative Example 9	3.70	1124	654	7.1	-
Comparative Example 10	4.16	1026	689	6.9	-
Comparative Example 11	4.45	1176	563	7.1	-
Comparative Example 12	4.66	1015	597	7.0	-
Comparative Example 13	4.74	892	498	6.2	-
Comparative Example 14	4.46	1235	569	7.3	-

Table 4

Examples	Kind of low-density acicular hematite particles	Heat treatment for high densification		High-density acicular hematite particles	
		Temperature (°C)	Time (min)	Average major axial diameter (μm)	Average minor axial diameter (μm)
Example 22	Example 4	700	60	0.132	0.0210
Example 23	Example 5	730	60	0.138	0.0223
Example 24	Example 6	750	60	0.138	0.0230
Example 25	Example 7	600	15	0.169	0.0301
Example 26	Example 8	610	15	0.173	0.0288
Example 27	Example 9	650	30	0.186	0.0294
Example 28	Example 10	730	90	0.204	0.0315
Example 29	Example 11	750	120	0.137	0.0222
Example 30	Example 12	800	30	0.139	0.0243
Example 31	Example 13	750	30	0.211	0.0299
Example 32	Example 14	750	60	0.208	0.0296
Example 33	Example 15	730	60	0.189	0.0285
Example 34	Example 16	710	45	0.189	0.0298
Example 35	Example 17	750	30	0.139	0.0220
Example 36	Example 18	780	60	0.140	0.0219
Example 37	Example 19	680	60	0.141	0.0213
Example 38	Example 20	700	30	0.140	0.0211
Example 39	Example 21	700	60	0.142	0.0210

Table 4 (continued)

Examples	High-density acicular hematite particles				
	Geometrical standard deviation $\sigma_g$ (-)	Aspect ratio* (-)	$S_{BET}$ ( $m^2/g$ )	$S_{TEM}$ ( $m^2/g$ )	$S_{BET} / S_{TEM}$ (-)
Example 22	1.35	6.29	51.3	39.5	1.30
Example 23	1.38	6.19	46.8	37.3	1.26
Example 24	1.38	6.00	44.9	36.2	1.24
Example 25	1.35	5.61	38.5	27.8	1.38
Example 26	1.35	6.01	35.1	28.9	1.21
Example 27	1.35	6.33	33.7	28.2	1.19
Example 28	1.34	6.48	34.9	26.3	1.33
Example 29	1.39	6.17	51.0	37.5	1.36
Example 30	1.41	5.72	53.2	34.4	1.55
Example 31	1.44	7.06	37.5	27.5	1.36
Example 32	1.45	7.03	38.9	27.8	1.40
Example 33	1.33	6.63	40.1	29.0	1.38
Example 34	1.34	6.34	37.5	27.8	1.35
Example 35	1.36	6.32	55.9	37.7	1.48
Example 36	1.35	6.39	57.1	37.9	1.51
Example 37	1.36	6.62	51.2	38.8	1.32
Example 38	1.36	6.64	50.6	39.2	1.29
Example 39	1.36	6.76	51.6	39.3	1.31

(Note) \*: Aspect ratio = average major axial diameter/  
average minor axial diameter

Table 4 (continued)

Examples	High-density acicular hematite particles					
	Kind of Sintering preventive					
	Calculated as	Amount (wt. %)	Calculated as	Amount (wt. %)	Calculated as	Amount (wt. %)
Example 22	Sn	14.33	-	-	-	-
Example 23	Sn	18.06	-	-	-	-
Example 24	Sn	36.83	-	-	SiO <sub>2</sub>	0.62
Example 25	Sn	1.30	-	-	-	-
Example 26	Sn	3.16	-	-	-	-
Example 27	Sn	10.06	-	-	-	-
Example 28	Sn	35.81	-	-	-	-
Example 29	Sn	73.31	-	-	-	-
Example 30	Sn	91.68	-	-	-	-
Example 31	Sn	55.68	-	-	-	-
Example 32	Sn	47.15	P	0.48	-	-
Example 33	Sn	37.13	Sb	5.14	-	-
Example 34	Sn	9.65	Sb	2.01	-	-
Example 35	Sn	49.30	Sb	8.88	SiO <sub>2</sub>	1.41
Example 36	Sn	80.61	Sb	14.31	Al	0.96
Example 37	-	-	P	1.36	-	-
Example 38	-	-	-	-	SiO <sub>2</sub>	1.83
Example 39	-	-	P	0.51	SiO <sub>2</sub>	0.70

Table 4 (continued)

Examples	High-density acicular hematite particles		
	Soluble sodium salt (ppm)	Soluble sulfate (ppm)	pH value (-)
Example 22	1894	3400	5.1
Example 23	2561	3604	4.6
Example 24	2569	3448	5.7
Example 25	1205	3698	5.6
Example 26	1640	3948	5.2
Example 27	3063	3702	4.7
Example 28	3764	3591	5.8
Example 29	4182	3077	6.5
Example 30	5477	3475	6.8
Example 31	2911	4044	4.1
Example 32	2581	3931	4.5
Example 33	2219	2664	5.0
Example 34	2743	4669	4.1
Example 35	3485	2356	7.8
Example 36	3023	2768	6.8
Example 37	2682	3162	5.5
Example 38	2766	3082	5.8
Example 39	2826	3365	5.5

Table 5

Comparative Examples	Kind of low-density acicular hematite particles or acicular goethite particles	Heat treatment for high densification		High-density acicular hematite particles	
		Temperature (°C)	Time (min)	Average major axial diameter (μm)	Average minor axial diameter (μm)
Comparative Example 15	Example 1	720	15	0.075	0.0336
Comparative Example 16	Comparative Example 2	680	15	0.098	0.0286
Comparative Example 17	Comparative Example 4	700	30	0.125	0.0248
Comparative Example 18	Comparative Example 5	750	60	0.131	0.0220
Comparative Example 19	Comparative Example 6	570	90	0.134	0.0206
Comparative Example 20	Comparative Example 7	720	45	0.134	0.0201
Comparative Example 21	Comparative Example 8	730	30	0.132	0.0218
Comparative Example 22	Comparative Example 9	520	90	0.132	0.0198
Comparative Example 23	Comparative Example 10	720	15	0.191	0.0294
Comparative Example 24	Comparative Example 11	650	40	0.192	0.0288
Comparative Example 25	Comparative Example 12	600	15	0.192	0.0290
Comparative Example 26	Comparative Example 13	750	20	0.190	0.0300
Comparative Example 27	Comparative Example 14	460	60	0.185	0.0292

Table 5 (continued)

Comparative Examples	High-density acicular hematite particles				
	Geometrical standard deviation $\sigma_g$ (-)	Aspect ratio* (-)	$S_{BET}$ (m <sup>2</sup> /g)	$S_{STEM}$ (m <sup>2</sup> /g)	$S_{BET} / S_{STEM}$ (-)
Comparative Example 15	1.84	2.23	15.8	28.0	0.56
Comparative Example 16	1.71	3.43	21.9	30.8	0.71
Comparative Example 17	1.56	5.04	31.8	34.1	0.93
Comparative Example 18	1.36	5.95	45.6	37.9	1.20
Comparative Example 19	1.35	6.50	59.3	40.2	1.47
Comparative Example 20	1.35	6.67	52.6	41.1	1.28
Comparative Example 21	1.36	6.06	43.6	38.2	1.14
Comparative Example 22	1.34	6.67	68.9	41.8	1.65
Comparative Example 23	1.34	6.50	35.2	28.2	1.25
Comparative Example 24	1.33	6.67	43.9	28.7	1.53
Comparative Example 25	1.33	6.62	51.5	28.5	1.81
Comparative Example 26	1.34	6.33	37.5	27.7	1.36
Comparative Example 27	1.33	6.34	65.0	28.4	2.29

(Note) \*: Aspect ratio = average major axial diameter / average minor axial diameter

Table 5 (continued)

Comparative Example	High-density acicular hematite particles					
	Kind of Sintering preventive		Soluble sodium salt (ppm)	Soluble sulfate (ppm)	pH value (-)	Volume resistivity ( $\Omega$ cm)
	Calculated as	Amount (wt. %)				
Comparative Example 15	-	-	1658	3256	5.3	$5.6 \times 10^8$
Comparative Example 16	-	-	1745	3569	5.3	$8.9 \times 10^8$
Comparative Example 17	P	0.44	1652	3756	5.1	$3.8 \times 10^8$
Comparative Example 18	SiO <sub>2</sub>	0.93	1548	3874	4.9	$7.1 \times 10^8$
Comparative Example 19	P	0.46	1436	2964	5.3	-
Comparative Example 20	SiO <sub>2</sub>	1.40	1569	3684	5.1	-
Comparative Example 21	SiO <sub>2</sub>	0.21	1856	3548	5.2	-
Comparative Example 22	P	0.74	1329	2456	5.6	-
Comparative Example 23	P	1.83	1954	3659	5.0	$3.8 \times 10^8$
Comparative Example 24	SiO <sub>2</sub>	1.22	2045	3246	5.6	-
Comparative Example 25	P	1.46	1564	2857	5.2	-
Comparative Example 26	SiO <sub>2</sub>	0.23	1186	3156	4.7	-
Comparative Example 27	Sn	0.05	2356	3247	5.6	-

Table 6

Examples	Kind of high-density acicular hematite particles	Wet-pulverization step		Heat treatment in aqueous alkaline solution		
		Use or non-use	Residue on sieve (wt. %)	pH (-)	Temperature (°C)	Time (min)
Example 40	Example 22	used	0	13.1	98	180
Example 41	Example 23	used	0	13.5	94	180
Example 42	Example 24	used	0	13.3	95	180
Example 43	Example 25	used	0	13.8	91	120
Example 44	Example 26	used	0	13.8	95	90
Example 45	Example 27	used	0	13.5	95	90
Example 46	Example 28	used	0	13.6	95	180
Example 47	Example 29	used	0	13.5	92	180
Example 48	Example 30	used	0	13.7	95	120
Example 49	Example 31	used	0	13.3	90	120
Example 50	Example 32	used	0	13.5	97	120
Example 51	Example 33	used	0	13.8	97	60
Example 52	Example 34	used	0	13.7	95	60
Example 53	Example 35	used	0	13.2	90	120
Example 54	Example 36	used	0	13.6	95	180
Example 55	Example 37	used	0	13.1	95	180
Example 56	Example 38	used	0	13.5	95	180
Example 57	Example 39	used	0	13.3	95	180

Table 7

Examples	Acicular hematite particles washed with water after aqueous alkaline solution treatment			
	Average major axial diameter ( $\mu\text{m}$ )	Average minor axial diameter ( $\mu\text{m}$ )	Geometrical standard deviation $\sigma_g$ (-)	Aspect ratio* (-)
Example 40	0.132	0.0209	1.35	6.32
Example 41	0.138	0.0223	1.38	6.19
Example 42	0.137	0.0230	1.38	5.96
Example 43	0.170	0.0301	1.35	5.65
Example 44	0.172	0.0288	1.34	5.97
Example 45	0.186	0.0294	1.35	6.33
Example 46	0.203	0.0314	1.34	6.46
Example 47	0.138	0.0222	1.39	6.22
Example 48	0.139	0.0243	1.40	5.72
Example 49	0.210	0.0298	1.44	7.05
Example 50	0.209	0.0296	1.44	7.06
Example 51	0.188	0.0285	1.34	6.60
Example 52	0.189	0.0298	1.35	6.34
Example 53	0.140	0.0220	1.36	6.36
Example 54	0.140	0.0219	1.37	6.39
Example 55	0.141	0.0213	1.36	6.62
Example 56	0.141	0.0211	1.36	6.68
Example 57	0.143	0.0210	1.36	6.81

(Note) \*: Aspect ratio = average major axial diameter / average minor axial diameter

Table 7 (continued)

Examples	Acicular hematite particles washed with water after aqueous alkaline solution treatment		
	$S_{\text{BET}}$ (m <sup>2</sup> /g)	$S_{\text{TEM}}$ (m <sup>2</sup> /g)	$S_{\text{BET}} / S_{\text{TEM}}$ (-)
Example 40	52.2	39.7	1.31
Example 41	47.1	37.3	1.26
Example 42	43.7	36.3	1.21
Example 43	38.9	27.8	1.40
Example 44	36.1	28.9	1.25
Example 45	34.0	28.2	1.20
Example 46	35.5	26.4	1.35
Example 47	50.6	37.4	1.35
Example 48	52.5	34.4	1.53
Example 49	36.9	27.6	1.33
Example 50	38.3	27.8	1.38
Example 51	40.8	29.0	1.41
Example 52	36.8	27.8	1.32
Example 53	54.8	37.7	1.45
Example 54	56.5	37.9	1.49
Example 55	50.6	38.8	1.30
Example 56	50.8	39.2	1.30
Example 57	51.9	39.3	1.32

Table 7 (continued)

Examples	Acicular hematite particles washed with water after aqueous alkaline solution treatment					
	Kind of Sintering preventive					
	Calculated as	Amount (wt. %)	Calculated as	Amount (wt. %)	Calculated as	Amount (wt. %)
Example 40	Sn	14.16	-	-	-	-
Example 41	Sn	17.92	-	-	-	-
Example 42	Sn	36.65	-	-	SiO <sub>2</sub>	0.60
Example 43	Sn	1.30	-	-	-	-
Example 44	Sn	3.14	-	-	-	-
Example 45	Sn	9.68	-	-	-	-
Example 46	Sn	35.60	-	-	-	-
Example 47	Sn	72.10	-	-	-	-
Example 48	Sn	90.01	-	-	-	-
Example 49	Sn	53.65	-	-	-	-
Example 50	Sn	45.89	P	0.26	-	-
Example 51	Sn	35.68	Sb	5.16	-	-
Example 52	Sn	9.26	Sb	1.86	-	-
Example 53	Sn	48.65	Sb	8.62	SiO <sub>2</sub>	1.36
Example 54	Sn	76.56	Sb	13.68	Al	0.98
Example 55	-	-	P	0.72	-	-
Example 56	-	-	-	-	SiO <sub>2</sub>	1.80
Example 57	-	-	P	0.25	SiO <sub>2</sub>	0.68

Table 7 (continued)

Examples	Acicular hematite particles washed with water after aqueous alkaline solution treatment			
	Soluble sodium salt (ppm)	Soluble sulfate (ppm)	pH value (-)	Volume resistivity ( $\Omega\text{cm}$ )
Example 40	108	13	9.3	$3.2 \times 10^6$
Example 41	135	32	9.0	$1.7 \times 10^6$
Example 42	87	23	9.1	$1.1 \times 10^6$
Example 43	78	24	8.8	$3.8 \times 10^7$
Example 44	121	32	9.4	$3.1 \times 10^7$
Example 45	98	46	8.6	$8.2 \times 10^6$
Example 46	105	48	8.9	$1.0 \times 10^6$
Example 47	124	11	9.0	$5.8 \times 10^5$
Example 48	138	21	9.5	$2.6 \times 10^5$
Example 49	76	15	8.8	$9.1 \times 10^5$
Example 50	89	21	8.9	$7.0 \times 10^5$
Example 51	107	17	9.3	$6.9 \times 10^5$
Example 52	124	16	9.1	$2.6 \times 10^6$
Example 53	79	8	9.0	$3.3 \times 10^5$
Example 54	87	8	8.9	$1.3 \times 10^5$
Example 55	115	15	9.2	$8.9 \times 10^8$
Example 56	121	21	9.4	$6.5 \times 10^8$
Example 57	89	32	8.9	$5.1 \times 10^8$

Table 8

Comparative Examples	Kind of acicular hematite particles	Wet-pulverization step		Heat treatment in aqueous alkaline solution		
		Use or non-use	Residue on sieve (wt. %)	pH (-)	Temperature (°C)	Time (min)
Comparative Example 28	Comparative Example 19	used	0	-	-	-
Comparative Example 29	Comparative Example 20	used	0	11.5	93	180
Comparative Example 30	Comparative Example 21	used	0	13.3	50	180
Comparative Example 31	Comparative Example 22	unused	18.0	13.3	90	180
Comparative Example 32	Comparative Example 24	unused	19.6	10.5	95	180
Comparative Example 33	Comparative Example 25	unused	23.6	13.3	92	120
Comparative Example 34	Comparative Example 26	unused	17.5	13.5	90	120
Comparative Example 35	Comparative Example 27	used	0	9.5	95	120

Table 9

Comparative Examples	Acicular hematite particles washed with water after aqueous alkaline solution treatment			
	Average major axial diameter ( $\mu\text{m}$ )	Average minor axial diameter ( $\mu\text{m}$ )	Geometrical standard deviation $\sigma_g$ (-)	Aspect ratio* (-)
Comparative Example 28	0.134	0.0206	1.35	6.50
Comparative Example 29	0.134	0.0200	1.35	6.70
Comparative Example 30	0.132	0.0218	1.35	6.06
Comparative Example 31	0.132	0.0198	1.35	6.67
Comparative Example 32	0.192	0.0288	1.35	6.67
Comparative Example 33	0.192	0.0291	1.34	6.60
Comparative Example 34	0.191	0.0302	1.35	6.32
Comparative Example 35	0.185	0.0292	1.33	6.34

(Note) \*: Aspect ratio = average major axial diameter/  
average minor axial diameter

Table 9 (continued)

Comparative Examples	Acicular hematite particles washed with water after aqueous alkaline solution treatment		
	$S_{\text{BET}}$ (m <sup>2</sup> /g)	$S_{\text{TEM}}$ (m <sup>2</sup> /g)	$S_{\text{BET}} / S_{\text{TEM}}$ (-)
Comparative Example 28	58.8	40.2	1.46
Comparative Example 29	52.6	41.3	1.27
Comparative Example 30	44.1	38.2	1.15
Comparative Example 31	69.1	41.8	1.65
Comparative Example 32	43.7	28.7	1.52
Comparative Example 33	50.9	28.4	1.79
Comparative Example 34	38.0	27.5	1.38
Comparative Example 35	63.8	28.4	2.24

Table 9 (continued)

Comparative Examples	Acicular hematite particles washed with water after aqueous alkaline solution treatment					
	Kind of Sintering preventive		Soluble sodium salt (ppm)	Soluble sulfate (ppm)	pH value (-)	Specific volume resistivity ( $\Omega\text{cm}$ )
	Calculated as	Amount (wt. %)				
Comparative Example 28	P	0.46	658	354	7.1	$5.1 \times 10^8$
Comparative Example 29	SiO <sub>2</sub>	1.38	452	316	7.0	$6.7 \times 10^8$
Comparative Example 30	SiO <sub>2</sub>	0.21	365	197	7.7	$7.4 \times 10^8$
Comparative Example 31	P	0.75	312	165	7.9	$8.0 \times 10^8$
Comparative Example 32	SiO <sub>2</sub>	1.20	703	335	7.0	$6.1 \times 10^8$
Comparative Example 33	P	1.44	321	185	7.5	$7.9 \times 10^8$
Comparative Example 34	SiO <sub>2</sub>	0.23	376	167	7.9	$3.7 \times 10^8$
Comparative Example 35	SiO <sub>2</sub>	0.04	832	349	7.1	$8.6 \times 10^7$

Table 10

Examples	Kind of acicular hematite particles treated with aqueous alkaline solution	Surface treatment		Coating substance	
		Kind	Amount added (calculated as each element) (wt. %)	Calculated as	Amount (wt. %)
Example 58	Example 40	Sodium aluminate	1.3	Al	1.28
Example 59	Example 41	Water glass #3	0.5	SiO <sub>2</sub>	0.45
Example 60	Example 42	Aluminum sulfate	1.0	Al	0.99
Example 61	Example 43	Colloidal silica	1.0	SiO <sub>2</sub>	0.96

Table 10 (continued)

Examples	Kind of acicular hematite particles treated with aqueous alkaline solution	Surface treatment		Coating substance	
		Kind	Amount added (calculated as each element) (wt. %)	Calculated as	Amount (wt. %)
Example 62	Example 44	Aluminum acetate Water glass #3	1.5 0.8	Al SiO <sub>2</sub>	1.46 0.77
Example 63	Example 45	Aluminum sulfate Water glass #3	0.3 2.5	Al SiO <sub>2</sub>	0.30 2.38
Example 64	Example 46	Sodium aluminate	5.0	Al	4.76
Example 65	Example 47	Sodium aluminate	1.5	Al	1.46
		Colloidal silica	2.5	SiO <sub>2</sub>	2.36
Example 66	Example 48	Sodium aluminate	0.2	Al	0.20
Example 67	Example 49	Aluminum acetate	10.0	Al	9.01
		Colloidal silica	0.3	SiO <sub>2</sub>	0.28
Example 68	Example 50	Water glass #3	3.0	SiO <sub>2</sub>	2.90
Example 69	Example 51	Sodium aluminate	1.8	Al	1.76
Example 70	Example 52	Aluminum acetate	0.2	Al	0.20
Example 71	Example 53	Sodium aluminate	3.0	Al	2.91
Example 72	Example 54	Water glass #3	1.5	SiO <sub>2</sub>	1.45
Example 73	Example 55	Sodium stannate	3.0	Sn	2.90
Example 74	Example 56	Stannous chloride	5.0	Sn	4.71
Example 75	Example 57	Sodium stannate	5.5	Sn	5.11
		Antimony chloride	0.5	Sb	0.47

Table 11

Examples	Properties of acicular hematite particles washed with water after aqueous alkaline solution treatment			
	Average major axial diameter ( $\mu\text{m}$ )	Average minor axial diameter ( $\mu\text{m}$ )	Geometrical standard deviation $\sigma_g$ (-)	Aspect ratio* (-)
Example 58	0.132	0.0209	1.35	6.32
Example 59	0.137	0.0222	1.38	6.17
Example 60	0.137	0.0231	1.38	5.93
Example 61	0.170	0.0300	1.35	5.67
Example 62	0.171	0.0288	1.35	5.94
Example 63	0.187	0.0294	1.35	6.36
Example 64	0.202	0.0313	1.34	6.45
Example 65	0.138	0.0222	1.39	6.22
Example 66	0.139	0.0244	1.40	5.70
Example 67	0.209	0.0298	1.44	7.01
Example 68	0.210	0.0296	1.44	7.09
Example 69	0.188	0.0285	1.34	6.60
Example 70	0.189	0.0298	1.35	6.34
Example 71	0.141	0.0221	1.36	6.38
Example 72	0.140	0.0220	1.37	6.36
Example 73	0.141	0.0213	1.36	6.62
Example 74	0.141	0.0211	1.36	6.68
Example 75	0.143	0.0210	1.36	6.81

(Note) \*: Aspect ratio = average major axial diameter / average minor axial diameter

Table 11 (continued)

Examples	Properties of acicular hematite particles washed with water after aqueous alkaline solution treatment		
	$S_{\text{BET}}$ (m <sup>2</sup> /g)	$S_{\text{TEM}}$ (m <sup>2</sup> /g)	$S_{\text{BET}} / S_{\text{TEM}}$ (-)
Example 58	51.9	39.7	1.31
Example 59	46.9	37.5	1.25
Example 60	43.2	36.1	1.20
Example 61	38.7	27.9	1.39
Example 62	36.0	29.0	1.24
Example 63	35.3	28.2	1.25
Example 64	36.5	26.5	1.38
Example 65	52.3	37.4	1.40
Example 66	51.5	34.3	1.50
Example 67	40.0	27.7	1.45
Example 68	40.8	27.8	1.47
Example 69	40.1	29.0	1.38
Example 70	36.5	27.8	1.31
Example 71	55.1	37.5	1.47
Example 72	55.6	37.7	1.47
Example 73	51.0	38.8	1.31
Example 74	52.6	39.2	1.34
Example 75	52.6	39.3	1.34

Table 11 (continued)

Examples	Properties of acicular hematite particles washed with water after aqueous alkaline solution treatment					
	Kind of Sintering preventive					
	Calculated as	Amount (wt. %)	Calculated as	Amount (wt. %)	Calculated as	Amount (wt. %)
Example 58	Sn	13.75	-	-	-	-
Example 59	Sn	17.68	-	-	-	-
Example 60	Sn	34.52	-	-	SiO <sub>2</sub>	0.58
Example 61	Sn	1.28	-	-	-	-
Example 62	Sn	3.06	-	-	-	-
Example 63	Sn	9.22	-	-	-	-
Example 64	Sn	33.81	-	-	-	-
Example 65	Sn	70.12	-	-	-	-
Example 66	Sn	88.82	-	-	-	-
Example 67	Sn	48.77	-	-	-	-
Example 68	Sn	44.00	P	0.25	-	-
Example 69	Sn	34.68	Sb	5.11	-	-
Example 70	Sn	8.92	Sb	1.83	-	-
Example 71	Sn	47.32	Sb	8.58	SiO <sub>2</sub>	1.36
Example 72	Sn	74.82	Sb	12.99	Al	0.98
Example 73	-	-	P	0.69	-	-
Example 74	-	-	-	-	SiO <sub>2</sub>	1.71
Example 75	-	-	P	0.23	SiO <sub>2</sub>	0.64

Table 11 (continued)

Examples	Properties of acicular hematite particles washed with water after aqueous alkaline solution treatment			
	Soluble sodium salt (ppm)	Soluble sulfate (ppm)	pH value (-)	Volume resistivity ( $\Omega\text{cm}$ )
Example 58	97	9	9.3	$4.1 \times 10^6$
Example 59	76	13	9.0	$1.8 \times 10^6$
Example 60	65	6	9.4	$1.3 \times 10^6$
Example 61	85	12	8.9	$5.0 \times 10^7$
Example 62	56	2	9.6	$4.5 \times 10^7$
Example 63	123	12	9.3	$1.2 \times 10^7$
Example 64	76	10	9.0	$2.3 \times 10^6$
Example 65	107	7	9.2	$6.9 \times 10^5$
Example 66	65	5	9.6	$2.5 \times 10^5$
Example 67	135	34	8.8	$2.4 \times 10^6$
Example 68	87	12	9.1	$9.3 \times 10^5$
Example 69	54	11	9.0	$8.8 \times 10^5$
Example 70	46	2	9.2	$2.7 \times 10^6$
Example 71	68	16	9.0	$6.4 \times 10^5$
Example 72	100	11	8.9	$2.5 \times 10^5$
Example 73	89	12	9.2	$6.8 \times 10^8$
Example 74	78	6	9.3	$3.2 \times 10^8$
Example 75	66	11	9.0	$1.1 \times 10^8$

Table 12

Examples	Kind of high-density acicular hematite particles	Heat treatment		Coating substance	
		Temperature ( $^{\circ}\text{C}$ )	Time (min)	Calculated as	Amount (wt. %)
Example 76	Example 73	400	60	Sn	2.92
Example 77	Example 74	350	60	Sn	4.75
Example 78	Example 75	380	90	Sn Sb	5.32 0.49

Table 13

Examples	Properties of acicular hematite particles washed with water after treatment with tin compound			
	Average major axial diameter ( $\mu\text{m}$ )	Average minor axial diameter ( $\mu\text{m}$ )	Geometrical standard deviation $\sigma_g$ (-)	Aspect ratio* (-)
Example 76	0.141	0.0213	1.36	6.62
Example 77	0.141	0.0210	1.36	6.71
Example 78	0.143	0.0209	1.36	6.84

(Note) \*: Aspect ratio = average major axial diameter / average minor axial diameter

Table 13 (continued)

Examples	Properties of acicular hematite particles washed with water after treatment with tin compound		
	$S_{\text{BET}}$ (m <sup>2</sup> /g)	$S_{\text{TEM}}$ (m <sup>2</sup> /g)	$S_{\text{BET}} / S_{\text{TEM}}$ (-)
Example 76	50.6	38.8	1.30
Example 77	51.1	39.4	1.30
Example 78	51.9	39.5	1.31

Table 13 (continued)

Examples	Properties of acicular hematite particles washed with water after treatment with tin compound	
	Kind of Sintering preventive	
	Calculated as	Amount (wt. %)
Example 76	P	0.70
Example 77	SiO <sub>2</sub>	1.74
Example 78	P	0.24
	SiO <sub>2</sub>	0.67

Table 13 (continued)

Examples	Properties of acicular hematite particles washed with water after treatment with tin compound			
	Soluble sodium salt (ppm)	Soluble sulfate (ppm)	pH value (-)	Volume resistivity ( $\Omega\text{cm}$ )
Example 76	125	15	8.9	$2.6 \times 10^6$
Example 77	115	26	9.0	$8.1 \times 10^6$
Example 78	91	32	9.0	$1.6 \times 10^6$

Table 14

	Production of non-magnetic coating material		Non-magnetic coating material
Examples	Kind of acicular hematite particles	Weight ratio of particles to resin (-)	Viscosity (cP)
Example 79	Example 40	5.0	410
Example 80	Example 41	5.0	435
Example 81	Example 42	5.0	384
Example 82	Example 43	5.0	333
Example 83	Example 44	5.0	205
Example 84	Example 45	5.0	179
Example 85	Example 46	5.0	128
Example 86	Example 47	5.0	742
Example 87	Example 48	5.0	896
Example 88	Example 49	5.0	205
Example 89	Example 50	5.0	230
Example 90	Example 51	5.0	512
Example 91	Example 52	5.0	384
Example 92	Example 53	5.0	768
Example 93	Example 54	5.0	819
Example 94	Example 58	5.0	384
Example 95	Example 59	5.0	384

Table 14 (continued)

Examples	Non-magnetic undercoat layer			
	Thickness of coating layer ( $\mu\text{m}$ )	Gloss (%)	Surface roughness Ra (nm)	Young's modulus (relative value)
Example 79	3.5	190	7.2	126
Example 80	3.4	186	7.5	124
Example 81	3.4	181	7.8	125
Example 82	3.4	198	6.8	129
Example 83	3.3	196	6.8	127
Example 84	3.5	194	7.6	133
Example 85	3.5	188	8.4	131
Example 86	3.4	185	8.8	124
Example 87	3.3	180	10.4	123
Example 88	3.5	187	8.0	134
Example 89	3.4	191	7.8	136
Example 90	3.5	195	7.4	128
Example 91	3.4	199	7.0	131
Example 92	3.5	185	8.6	124
Example 93	3.5	185	8.3	126
Example 94	3.4	185	7.0	128
Example 95	3.5	180	7.3	125

Table 15

	Production of non-magnetic coating material		Non-magnetic coating material
Examples	Kind of acicular hematite particles	Weight ratio of particles to resin (-)	Viscosity (cP)
Example 96	Example 60	5.0	307
Example 97	Example 61	5.0	333
Example 98	Example 62	5.0	179
Example 99	Example 63	5.0	128
Example 100	Example 64	5.0	102
Example 101	Example 65	5.0	512
Example 102	Example 66	5.0	768
Example 103	Example 67	5.0	179
Example 104	Example 68	5.0	205
Example 105	Example 69	5.0	384
Example 106	Example 70	5.0	230
Example 107	Example 71	5.0	410
Example 108	Example 72	5.0	435
Example 109	Example 76	5.0	384
Example 110	Example 77	5.0	435
Example 111	Example 78	5.0	512

Table 15 (continued)

Examples	Non-magnetic undercoat layer			
	Thickness of coating layer ( $\mu\text{m}$ )	Gloss (%)	Surface roughness Ra (nm)	Young's modulus (relative value)
Example 96	3.4	191	7.3	127
Example 97	3.4	205	6.8	131
Example 98	3.4	200	6.5	131
Example 99	3.3	193	7.4	136
Example 100	3.4	195	7.9	134
Example 101	3.4	190	8.3	125
Example 102	3.5	188	8.6	125
Example 103	3.5	193	8.8	136
Example 104	3.4	194	8.5	139
Example 105	3.5	196	8.0	131
Example 106	3.4	207	6.8	135
Example 107	3.3	190	7.4	127
Example 108	3.4	195	7.3	127
Example 109	3.4	195	7.5	128
Example 110	3.4	198	7.2	128
Example 111	3.4	201	6.9	129

Table 16

Comparative Examples	Production of non-magnetic coating material		Non-magnetic coating material
	Kind of acicular hematite particles	Weight ratio of particles to resin (-)	Viscosity (cP)
Comparative Example 36	Comparative Example 1	5.0	25600
Comparative Example 37	Comparative Example 15	5.0	128
Comparative Example 38	Comparative Example 16	5.0	102
Comparative Example 39	Comparative Example 3	5.0	20480
Comparative Example 40	Comparative Example 17	5.0	768
Comparative Example 41	Comparative Example 18	5.0	563
Comparative Example 42	Comparative Example 28	5.0	435
Comparative Example 43	Comparative Example 29	5.0	405
Comparative Example 44	Comparative Example 30	5.0	384
Comparative Example 45	Comparative Example 31	5.0	640
Comparative Example 46	Comparative Example 23	5.0	512
Comparative Example 47	Comparative Example 32	5.0	435
Comparative Example 48	Comparative Example 33	5.0	435
Comparative Example 49	Comparative Example 34	5.0	410
Comparative Example 50	Comparative Example 35	5.0	2560

Table 16 (continued)

Comparative Examples	Non-magnetic undercoat layer			
	Thickness of coating layer ( $\mu\text{m}$ )	Gloss (%)	Surface roughness Ra (nm)	Young's modulus (relative value)
Comparative Example 36	3.6	68	112.0	76
Comparative Example 37	3.5	45	181.0	58
Comparative Example 38	3.5	89	78.5	86
Comparative Example 39	3.7	76	84.0	77
Comparative Example 40	3.5	135	33.8	103
Comparative Example 41	3.5	159	23.1	105
Comparative Example 42	3.5	170	15.9	110
Comparative Example 43	3.6	176	13.1	112
Comparative Example 44	3.5	175	13.2	110
Comparative Example 45	3.6	165	17.0	105
Comparative Example 46	3.7	147	21.7	109
Comparative Example 47	3.6	167	18.6	112
Comparative Example 48	3.8	171	16.2	110
Comparative Example 49	3.5	175	14.4	114
Comparative Example 50	3.6	148	22.7	104

Table 17

Examples	Magnetic recording medium using magnetic particles containing iron as main ingredient		
	Kind of Non-magnetic undercoat layer	Kind of magnetic particles containing iron as main ingredient	Weight ratio of magnetic particles to resin (-)
Example 112	Example 79	[major axial diameter = 0.10 $\mu\text{m}$ ; minor axial diameter = 0.016 $\mu\text{m}$ ;	5.0
Example 113	Example 80	aspect ratio = 6.3;	5.0
Example 114	Example 81	Hc = 1926 Oe;	5.0
Example 115	Example 82	$\sigma_s$ = 131.0 emu/g;	5.0
Example 116	Example 83	pH value = 10.3;	5.0
Example 117	Example 84	Al content = 4.11 wt. %;	5.0
Example 118	Example 85	Co content = 5.87 wt. %]	5.0
Example 119	Example 86	[major axial diameter = 0.12 $\mu\text{m}$ ;	5.0
Example 120	Example 87	minor axial diameter = 0.018 $\mu\text{m}$ ;	5.0
Example 121	Example 88	aspect ratio = 7.0;	5.0
Example 122	Example 89	Hc = 1770 Oe;	5.0
Example 123	Example 90	$\sigma_s$ = 138.0 emu/g;	5.0
Example 124	Example 91	pH value = 9.8;	5.0
Example 125	Example 92	Al content = 2.27 wt. %;	5.0
Example 126	Example 93	Co content = 3.72 wt. %]	5.0

Table 17 (continued)

Examples	Magnetic recording medium using magnetic particles containing iron as main ingredient				
	Thickness of magnetic layer ( $\mu\text{m}$ )	Coercive force (Oe)	Br/Bm (-)	Gloss (%)	Surface roughness Ra (nm)
Example 112	1.1	2022	0.88	210	7.0
Example 113	1.1	2035	0.88	206	7.0
Example 114	1.1	2041	0.88	205	7.6
Example 115	1.0	2087	0.88	221	6.4
Example 116	1.1	2036	0.88	223	6.3
Example 117	1.1	2026	0.87	212	7.0
Example 118	1.1	2016	0.88	208	7.4
Example 119	1.1	1856	0.89	203	8.0
Example 120	1.2	1836	0.87	196	8.6
Example 121	1.1	1897	0.88	200	7.6
Example 122	1.0	1893	0.89	211	7.4
Example 123	1.1	1834	0.89	209	7.2
Example 124	1.1	1867	0.90	227	6.5
Example 125	1.2	1870	0.88	213	7.0
Example 126	1.1	1867	0.88	216	7.0

Table 17 (continued)

Examples	Magnetic recording medium using magnetic particles containing iron as main ingredient				
	Young's modulus (relative value)	Linear absorption coefficient ( $\mu\text{m}^{-1}$ )	Surface resistivity ( $\Omega/\text{sq}$ )	Corrosion property	
				Rate of change in coercive force (%)	Rate of change in Bm (%)
Example 112	131	1.23	$9.6 \times 10^7$	7.9	6.9
Example 113	130	1.24	$5.1 \times 10^7$	6.4	5.4
Example 114	132	1.21	$9.8 \times 10^7$	5.3	5.8
Example 115	134	1.27	$4.6 \times 10^7$	5.7	6.9
Example 116	134	1.29	$4.4 \times 10^7$	7.3	6.4
Example 117	138	1.31	$1.8 \times 10^8$	3.7	4.8
Example 118	135	1.31	$8.8 \times 10^7$	6.4	7.9
Example 119	130	1.20	$6.4 \times 10^6$	4.8	6.3
Example 120	131	1.20	$7.8 \times 10^5$	5.3	7.2
Example 121	139	1.30	$8.6 \times 10^6$	8.6	7.6
Example 122	141	1.31	$7.3 \times 10^6$	7.4	7.9
Example 123	132	1.28	$1.0 \times 10^7$	5.8	6.8
Example 124	133	1.26	$7.8 \times 10^7$	6.7	5.2
Example 125	130	1.23	$6.5 \times 10^6$	6.6	4.8
Example 126	130	1.22	$8.7 \times 10^5$	3.6	3.5

Table 18

Examples	Magnetic recording medium using magnetic particles containing iron as main ingredient		
	Kind of Non-magnetic undercoat layer	Kind of magnetic particles containing iron as main ingredient	Weight ratio of magnetic particles to resin (-)
Example 127	Example 94	[major axial diameter = 0.10 $\mu\text{m}$ ; minor axial diameter = 0.016 $\mu\text{m}$ ; aspect ratio = 6.3; Hc = 1926 Oe; $\sigma_s$ = 131.0 emu/g; pH value = 10.3; Al content = 4.11 wt. %; Co content = 5.87 wt. %]	5.0
Example 128	Example 95		5.0
Example 129	Example 96		5.0
Example 130	Example 97		5.0
Example 131	Example 98		5.0
Example 132	Example 99		5.0
Example 133	Example 100		5.0
Example 134	Example 101	[major axial diameter = 0.12 $\mu\text{m}$ ; minor axial diameter = 0.018 $\mu\text{m}$ ; aspect ratio = 7.0; Hc = 1770 Oe; $\sigma_s$ = 138.0 emu/g; pH value = 9.8; Al content = 2.27 wt. %; Co content = 3.72 wt. %]	5.0
Example 135	Example 102		5.0
Example 136	Example 103		5.0
Example 137	Example 104		5.0
Example 138	Example 105		5.0
Example 139	Example 106		5.0
Example 140	Example 107		5.0
Example 141	Example 108		5.0
Example 142	Example 109		5.0
Example 143	Example 110		5.0
Example 144	Example 111		5.0

Table 18 (continued)

Examples	Magnetic recording medium using magnetic particles containing iron as main ingredient				
	Thickness of magnetic layer ( $\mu\text{m}$ )	Coercive force (Oe)	Br/Bm (-)	Gloss (%)	Surface roughness Ra (nm)
Example 127	1.1	2032	0.89	223	6.8
Example 128	1.1	2043	0.88	215	7.0
Example 129	1.1	2036	0.89	209	7.3
Example 130	1.0	2075	0.88	220	6.4
Example 131	1.1	2046	0.90	225	6.2
Example 132	1.1	2050	0.89	227	6.8
Example 133	1.2	2043	0.90	219	7.2
Example 134	1.2	1864	0.90	218	7.6
Example 135	1.2	1845	0.88	209	9.0
Example 136	1.1	1887	0.88	210	7.4
Example 137	1.1	1895	0.90	217	7.0
Example 138	1.0	1845	0.90	217	7.0
Example 139	1.1	1876	0.91	236	6.1
Example 140	1.1	1881	0.88	218	6.8
Example 141	1.1	1875	0.89	223	6.7
Example 142	1.2	1881	0.89	211	7.5
Example 143	1.1	1872	0.90	215	7.3
Example 144	1.1	1865	0.90	216	7.0

Table 18 (continued)

Examples	Magnetic recording medium using magnetic particles containing iron as main ingredient				
	Young's modulus (relative value)	Linear absorption coefficient ( $\mu\text{m}^{-1}$ )	Surface resistivity ( $\Omega/\text{sq}$ )	Corrosion property	
				Rate of change in coercive force (%)	Rate of change in Bm (%)
Example 127	134	1.24	$9.6 \times 10^7$	4.5	4.7
Example 128	130	1.24	$5.3 \times 10^7$	5.4	4.9
Example 129	133	1.23	$1.0 \times 10^8$	4.5	4.7
Example 130	136	1.27	$4.6 \times 10^8$	5.5	6.6
Example 131	137	1.29	$4.8 \times 10^8$	6.8	6.3
Example 132	141	1.32	$2.5 \times 10^8$	3.2	3.8
Example 133	138	1.31	$9.9 \times 10^7$	3.6	4.7
Example 134	130	1.21	$7.2 \times 10^6$	3.7	5.1
Example 135	131	1.21	$8.5 \times 10^5$	5.0	6.4
Example 136	139	1.30	$9.0 \times 10^6$	6.8	6.5
Example 137	144	1.30	$8.7 \times 10^6$	6.1	6.0
Example 138	132	1.28	$2.1 \times 10^7$	4.7	5.5
Example 139	140	1.27	$8.4 \times 10^7$	5.4	4.1
Example 140	134	1.23	$8.0 \times 10^6$	2.9	3.7
Example 141	135	1.23	$9.8 \times 10^5$	2.8	2.9
Example 142	133	1.23	$3.6 \times 10^8$	7.2	6.8
Example 143	134	1.23	$2.1 \times 10^8$	8.1	6.8
Example 144	135	1.24	$9.6 \times 10^7$	6.0	5.2

Table 19

Comparative Examples	Magnetic recording medium using magnetic particles containing iron as main ingredient		
	Kind of Non-magnetic undercoat layer	Kind of magnetic particles containing iron as main ingredient	Weight ratio of magnetic particles to resin (-)
Comparative Example 51	Comparative Example 36	[major axial diameter = 0.10 $\mu\text{m}$ ; minor axial diameter = 0.016 $\mu\text{m}$ ; aspect ratio = 6.3; Hc = 1926 Oe; $\sigma_s$ = 131.0 emu/g; pH value = 10.3; Al content = 4.11 wt. %; Co content = 5.87 wt. %]	5.0
Comparative Example 52	Comparative Example 37		5.0
Comparative Example 53	Comparative Example 38		5.0
Comparative Example 54	Comparative Example 39		5.0
Comparative Example 55	Comparative Example 40		5.0
Comparative Example 56	Comparative Example 41		5.0
Comparative Example 57	Comparative Example 42		5.0
Comparative Example 58	Comparative Example 43		5.0
Comparative Example 59	Comparative Example 44		5.0
Comparative Example 60	Comparative Example 45		5.0
Comparative Example 61	Comparative Example 46		5.0
Comparative Example 62	Comparative Example 47		5.0
Comparative Example 63	Comparative Example 48		5.0
Comparative Example 64	Comparative Example 49		5.0
Comparative Example 65	Comparative Example 50		5.0

Table 19 (continued)

Comparative Examples	Magnetic recording medium using magnetic particles containing iron as main ingredient				
	Thickness of magnetic layer ( $\mu\text{m}$ )	Coercive force (Oe)	Br/Bm (-)	Gloss (%)	Surface roughness Ra (nm)
Comparative Example 51	1.3	1976	0.77	123	76.5
Comparative Example 52	1.2	1987	0.81	132	68.3
Comparative Example 53	1.2	1980	0.82	165	31.6
Comparative Example 54	1.2	1991	0.78	154	46.2
Comparative Example 55	1.2	2001	0.83	175	17.9
Comparative Example 56	1.3	2010	0.84	187	13.2
Comparative Example 57	1.1	2018	0.86	191	11.8
Comparative Example 58	1.3	2028	0.87	194	11.6
Comparative Example 59	1.1	1999	0.86	190	12.6
Comparative Example 60	1.2	2007	0.84	177	14.7
Comparative Example 61	1.1	1989	0.84	165	21.6
Comparative Example 62	1.0	2011	0.85	181	13.8
Comparative Example 63	1.3	1997	0.85	188	12.1
Comparative Example 64	1.3	2023	0.85	188	11.9
Comparative Example 65	1.2	2017	0.84	165	23.8

Table 19 (continued)

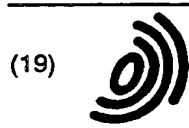
Comparative Examples	Magnetic recording medium using magnetic particles containing iron as main ingredient				
	Young's modulus (relative value)	Linear absorption coefficient ( $\mu\text{m}^{-1}$ )	Surface resistivity ( $\Omega/\text{sq}$ )	Corrosion property	
				Rate of change in coercive force (%)	Rate of change in B <sub>m</sub> (%)
Comparative Example 51	90	0.84	$8.9 \times 10^8$	27.5	25.4
Comparative Example 52	73	0.90	$8.3 \times 10^8$	38.9	31.1
Comparative Example 53	96	0.95	$9.6 \times 10^8$	49.8	36.8
Comparative Example 54	89	0.99	$1.1 \times 10^9$	28.2	23.7
Comparative Example 55	113	1.09	$1.3 \times 10^9$	46.9	39.7
Comparative Example 56	116	1.13	$8.7 \times 10^8$	37.6	33.3
Comparative Example 57	121	1.15	$2.3 \times 10^9$	17.1	15.8
Comparative Example 58	116	1.15	$1.0 \times 10^{10}$	14.2	13.8
Comparative Example 59	121	1.14	$7.2 \times 10^9$	16.4	16.7
Comparative Example 60	121	1.17	$3.6 \times 10^9$	16.3	19.0
Comparative Example 61	116	1.19	$1.8 \times 10^9$	37.4	31.6
Comparative Example 62	121	1.19	$4.1 \times 10^9$	18.9	23.1
Comparative Example 63	119	1.17	$7.2 \times 10^9$	15.7	18.5
Comparative Example 64	123	1.18	$6.5 \times 10^9$	18.5	16.9
Comparative Example 65	118	1.06	$9.6 \times 10^8$	23.7	24.8

#### Claims

- High-density acicular hematite particles (a) which comprise acicular hematite particles and a coat comprising an oxide of tin or oxides of tin and antimony on at least a part of surfaces of said acicular hematite particles; and (b) which have
  - an average major axial diameter of not more than  $0.3 \mu\text{m}$ ,
  - a pH value of not less than 8,
  - a soluble sodium salt content of not more than 300 ppm, calculated as Na, and
  - a soluble sulfate content of not more than 150 ppm, calculated as  $\text{SO}_4$ .
- High-density acicular hematite particles according to claim 1, wherein the amount of said oxide of tin is 0.5 to 500 % by weight, calculated as Sn, based of the weight of said acicular hematite particles.

3. High-density acicular hematite particles according to claim 1 or 2, wherein the amount of said oxide of antimony is 0.05 to 50 % by weight, calculated as Sb, based of the weight of said acicular hematite particles.
4. High-density acicular hematite particles according to any one of the preceding claims, wherein the weight ratio of tin to antimony is 20:1 to 1:1.
5. High-density acicular hematite particles according to any one of the preceding claims, which further have:
  - an aspect ratio (average major axial diameter:average minor axial diameter) of not less than 2:1; and/or
  - a degree of densification ( $S_{\text{BET}}/S_{\text{TEM}}$ ) of 0.5 to 2.5 wherein  $S_{\text{BET}}$  represents the specific surface area of said high-density acicular hematite particles measured by the BET method and  $S_{\text{TEM}}$  represents the surface area of said high-density acicular hematite particles calculated from the major axial and minor axial diameters of the particles measured on an electron microscope photograph; and/or
  - a particle size distribution of major axial diameter represented by a geometrical standard deviation of not more than 1.50; and/or
  - a BET specific surface area of not less than 35 m<sup>2</sup>/g; and/or
  - a volume resistivity of 10<sup>3</sup> to 5 x 10<sup>7</sup> Ωcm.
6. High-density acicular hematite particles according to any one of the preceding claims, which further comprise a coat on at least a part of surfaces of said high-density acicular hematite particles, said coat comprising at least one hydroxide or oxide selected from a hydroxide of aluminum, an oxide of aluminum, a hydroxide of silicon and an oxide of silicon.
7. High-density acicular hematite particles according to claim 6, wherein
  - the amount of said hydroxide of aluminum or said oxide of aluminum is 0.01 to 50 % by weight, calculated as Al, based of the weight of said acicular hematite particles; and/or
  - the amount of said hydroxide of silicon or said oxide of silicon is 0.01 to 50 % by weight, calculated as SiO<sub>2</sub>, based of the weight of said acicular hematite particles.
8. A non-magnetic substrate which carries an undercoat layer comprising high-density acicular hematite particles as defined in any one of the preceding claims and a binder resin.
9. A non-magnetic substrate according to claim 8, wherein the amount of said high-density acicular hematite particles is 5 to 2,000 parts by weight per 100 parts by weight of said binder resin.
10. A non-magnetic substrate according to claim 8 or 9 wherein
  - the undercoat layer has a thickness of 0.2 to 10.0 μm; and/or
  - a gloss of 180 to 280 % and a surface roughness of 2.0 to 13.0 nm.
11. A magnetic recording medium comprising:
  - a non-magnetic substrate;
  - a non-magnetic undercoat layer on said non-magnetic substrate and comprising high-density acicular hematite particles as defined in any one of claims 1 to 7 and a binder resin; and
  - a magnetic recording layer on said non-magnetic undercoat layer and comprising magnetic particles containing iron as a main ingredient and a binder resin.
12. A magnetic recording medium according to claim 11, wherein said magnetic particles containing iron as a main ingredient comprise 50 to 99 % by weight of iron, 0.05 to 10 % by weight of aluminum and at least one of Co, Ni, P, Si, Zn, Ti, Cu, B, Nd, La and Y.
13. A magnetic recording medium according to claim 11 or 12, wherein said magnetic particles containing iron as a main ingredient have an average major axial diameter of 0.01 to 0.50 μm, an average minor axial diameter of 0.0007 to 0.17 μm, an aspect ratio of not less than 3:1, a resin adsorptivity of not less than 65%, a coercive force of from 95.5 to 255 kA/m (from 1200 to 3200 Oe) and a saturation magnetization of from 100 to 170 Am<sup>2</sup>/kg (from 100 to 170 emu/g).

14. A magnetic recording medium according to any one of claims 11 to 13, which further has a coercive force of from 71.6 to 278 kA/m from (900 to 3500 Oe), a squareness of 0.85 to 0.95, a gloss of 195 to 300 %, a surface roughness of not more than 11.0 nm, a linear adsorption coefficient of 1.10 to 2.00  $\mu\text{m}^{-1}$  and a surface resistivity of  $10^4$  to  $5 \times 10^8 \Omega/\text{sq}$ .
15. A magnetic recording medium according to any one of claims 11 to 14, which further exhibits a coercive force change of not more than 10.0 % and a saturation magnetization flux change of not more than 10.0 %.
16. A process for producing high-density acicular hematite particles as defined in claim 1, comprising:
- (i) heat-dehydrating acicular goethite particles coated with a hydroxide of tin and, optionally, a hydroxide of antimony to obtain low-density acicular hematite particles;
  - (ii) heat-treating said low-density acicular hematite particles at a temperature of not less than 550°C to obtain high-density acicular hematite particles coated with an oxide of tin and, optionally, an oxide of antimony;
  - (iii) wet-pulverizing a slurry containing said high-density acicular hematite particles;
  - (iv) adjusting the pH value of said slurry to not less than 13;
  - (v) heat-treating said slurry at a temperature of not less than 808°C; and
  - (vi) filtering said slurry to separate the desired high-density acicular hematite particles therefrom, followed by washing with water and drying.
17. A process for producing high-density acicular hematite particles as defined claim 1, comprising:
- (a) wet-pulverizing a slurry containing high-density acicular hematite particles obtained by heat-treating at a temperature of not less than 550°C low-density acicular hematite particles produced by heat-dehydrating acicular goethite particles coated with a sintering preventive agent;
  - (b) adjusting the pH value of said slurry to not less than 13;
  - (c) heat-treating said slurry at a temperature of not less than 808°C;
  - (d) filtering said slurry to separate high-density acicular hematite particles therefrom, followed by washing with water and drying;
  - (e) treating the obtained high-density acicular hematite particles with an aqueous solution containing a tin compound and, optionally, an antimony compound to obtain high-density acicular hematite particles coated with a hydroxide of tin and, optionally, a hydroxide of antimony; and
  - (f) heat-treating said coated high-density acicular hematite particles coated at a temperature of not less than 300°C.



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(54) **High-density acicular hematite particles, non-magnetic undercoat layer and magnetic recording medium**

(57) High-density acicular hematite particles comprise acicular hematite particles and a coat comprising an oxide of tin or oxides of tin and antimony on at least a part of surfaces of said acicular hematite particles; and have

- an average major axial diameter of not more than 0.3  $\mu\text{m}$ ,
- a pH value of not less than 8,

- a soluble sodium salt content of not more than 300 ppm, calculated as Na, and
- a soluble sulfate content of not more than 150 ppm, calculated as  $\text{SO}_4$ .

Such high-density acicular hematite particles are suitable as non-magnetic particles for a non-magnetic undercoat layer of a magnetic recording medium using magnetic particles containing iron as a main ingredient.

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# EUROPEAN SEARCH REPORT

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Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
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			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
			C01G G11B C09C
The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
THE HAGUE		29 July 1999	LIBBERECHT, E
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